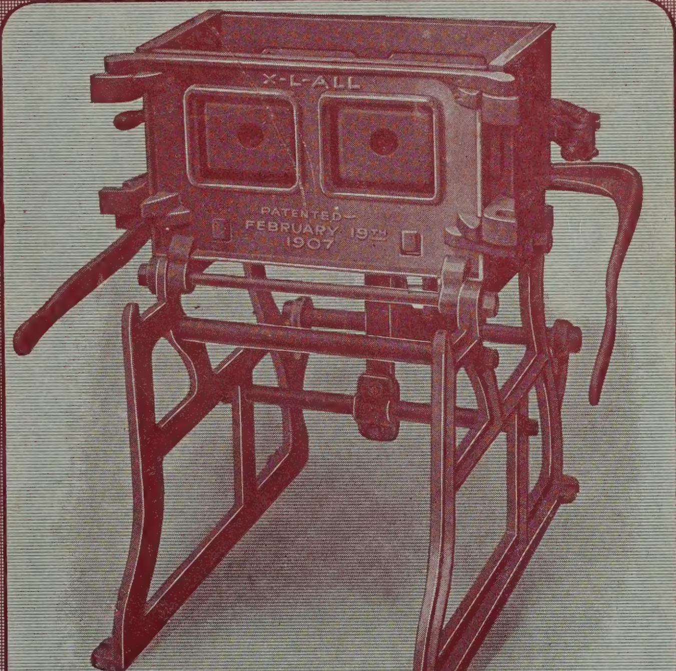
CEMENT BLOCK MACHINES

Cement Brick Machines
Concrete Mixers Etc.



SEARS, ROEBUCK & CO.
CHICAGO

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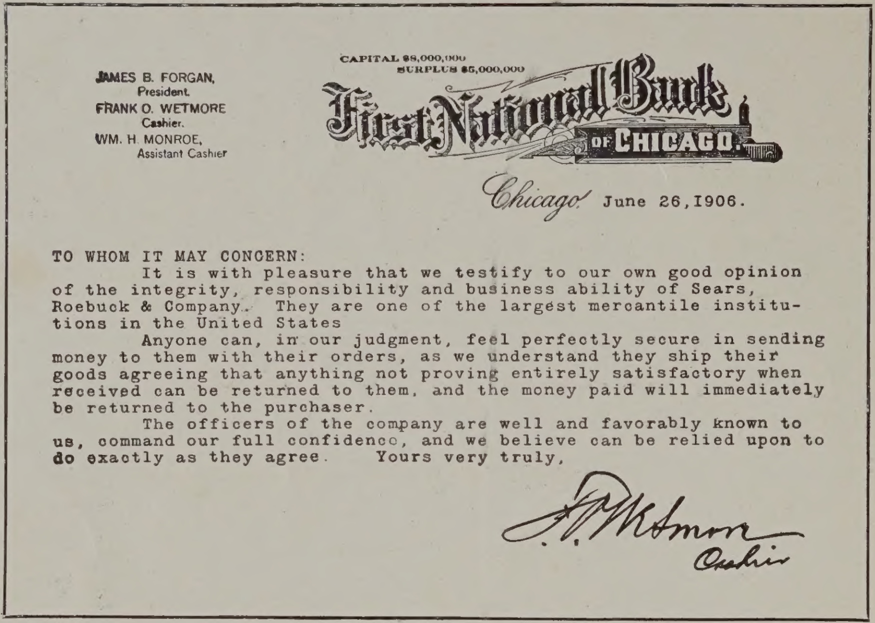

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Assistant Cashier

CAPITAL $8,000,000
SURPLUS $5,000,000
First National Bank
OF CHICAGO.

Chicago June 26, 1906.

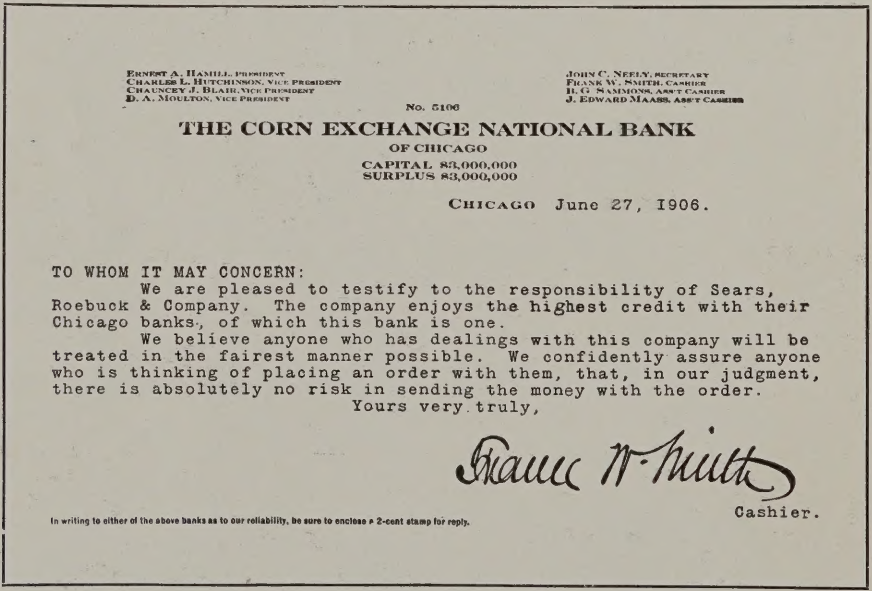
TO WHOM IT MAY CONCERN:

It is with pleasure that we testify to our own good opinion of the integrity, responsibility and business ability of Sears, Roebuck & Company. They are one of the largest mercantile institutions in the United States

Anyone can, in our judgment, feel perfectly secure in sending money to them with their orders, as we understand they ship their goods agreeing that anything not proving entirely satisfactory when received can be returned to them, and the money paid will immediately be returned to the purchaser.

The officers of the company are well and favorably known to us, command our full confidence, and we believe can be relied upon to do exactly as they agree. Yours very truly,

F. O. Wetmore
Cashier



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TO WHOM IT MAY CONCERN:

We are pleased to testify to the responsibility of Sears, Roebuck & Company. The company enjoys the highest credit with their Chicago banks, of which this bank is one.

We believe anyone who has dealings with this company will be treated in the fairest manner possible. We confidently assure anyone who is thinking of placing an order with them, that, in our judgment, there is absolutely no risk in sending the money with the order.

Yours very truly,

Frank W. Smith
Cashier.

In writing to either of the above banks as to our reliability, be sure to enclose a 2-cent stamp for reply.

w/14 pgs of cement Block homes

20.—

CATALOGUE OF

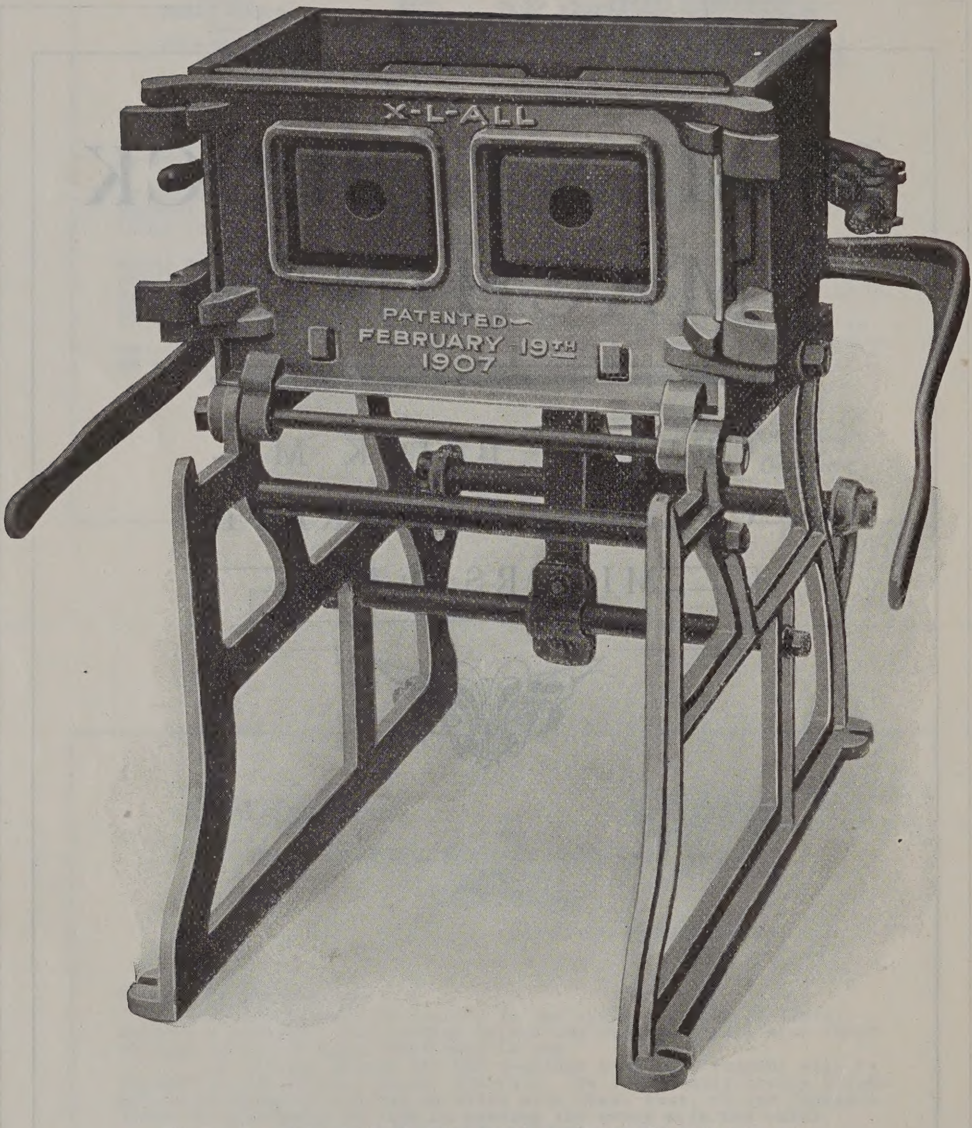
CEMENT BLOCK MACHINES

CEMENT BRICK MACHINES, CONCRETE MIXERS, ETC.

SOLD EXCLUSIVELY BY

SEARS, ROEBUCK & CO.,

CHICAGO, ILLINOIS.



X-L-ALL CEMENT BLOCK MACHINE.

THE NEW INDUSTRY

A NEW adaptation of an old process promises to revolutionize the building industry of the world. Within the last few years the uses of concrete, which is the name applied to a mixture of cement, sand, crushed stone, gravel or cinders and water, have multiplied many fold and today in every section of the world the use of cement building blocks and cement brick has become very common indeed. In fact, the use of cement blocks and cement brick has become so universal among builders that a description might seem almost unnecessary; but that this Catalogue of Cement Working Machinery and Accessories might be the most complete book of its kind ever published, that the most inexperienced and uninformed in the use of cement and concrete might be able to gain from its pages a complete working knowledge of this industry, a knowledge which is readily and easily applied in any community, we feel it incumbent upon us to explain this industry in every detail.

Concrete was known and used before the Christian era and concrete aqueducts, built before the time of Christ and still in good condition, are in use near the sacred city of Jerusalem. Of the seven wonders of the world, the Pyramids of Egypt were constructed of cement. There are concrete buildings in Rome that have been in daily use for more than 1,400 years, and in many of the countries of Europe and Asia there are castles, piles, moats and bridges which have withstood the onslaughts of the centuries. These facts are a sufficient answer to the inquiry, "Will cement endure; has it the quality of permanence and is it safe to use it in the construction of our homes, business blocks and other buildings?" It is an established fact that concrete sets harder and harder with age until it becomes solid rock, while, on the other hand, the ordinary clay brick of commerce, which for years was the most largely used building material, will soften and disintegrate in a comparatively short time. You have only to notice brick sidewalks in your community and compare them with cement walks laid even in the crudest fashion to discover that the cement sidewalk is almost everlasting, while the brick walk soon falls into decay.

Concrete construction, while long used in bridges and heavier masonry, has only sprung into general use within the last few years. Until very recently Portland cement was imported at prices ranging from $4.00 to $10.00 per barrel, which made it too expensive for general building purposes, but the discovery of inexhaustible beds of raw materials in almost every state in the Union, the establishment of Portland cement manufacturing plants in hundreds of communities, the development of new processes of mixing and making this cement reduced the cost to less than one-fourth of the former price and resulted in its very general introduction and use. It is now very generally conceded by architects and builders that concrete houses will in a few years almost entirely supersede both brick and frame.

Saved from the Lumber Trust

Gradually the immense resources of timber in the United States have given way before the plow, and the general prices of lumber have steadily advanced. In fact, in many classes of lumber, prices have doubled and trebled and in addition to the natural advance in price, due to the law of supply and demand, great combinations of lumbermen and millmen have secured a considerable control of the lumber industry and have created artificial values which have still further increased the cost of building materials. The constant development of concrete construction, the great reduction in the price of cement, the presence in every community of all the raw materials, such as gravel, stone, sand, etc., necessary in the making of cement blocks and cement brick have come to the builders' relief just at the opportune time, making it possible to build better buildings with cement blocks or cement brick for practically the same sum that is expended for first class brick, stone or frame construction, and in most cases the expense of building with cement is even less than where brick, stone or wood is used. The consumption of cement for concrete has therefore become something tremendous. In addition to its use in the building of homes, business blocks, barns, etc., bridges, piers, wharves, canals, aqueducts, retaining walls, sidewalks, railroad ties and fence posts are now made of concrete. In short, it is the building material of today.

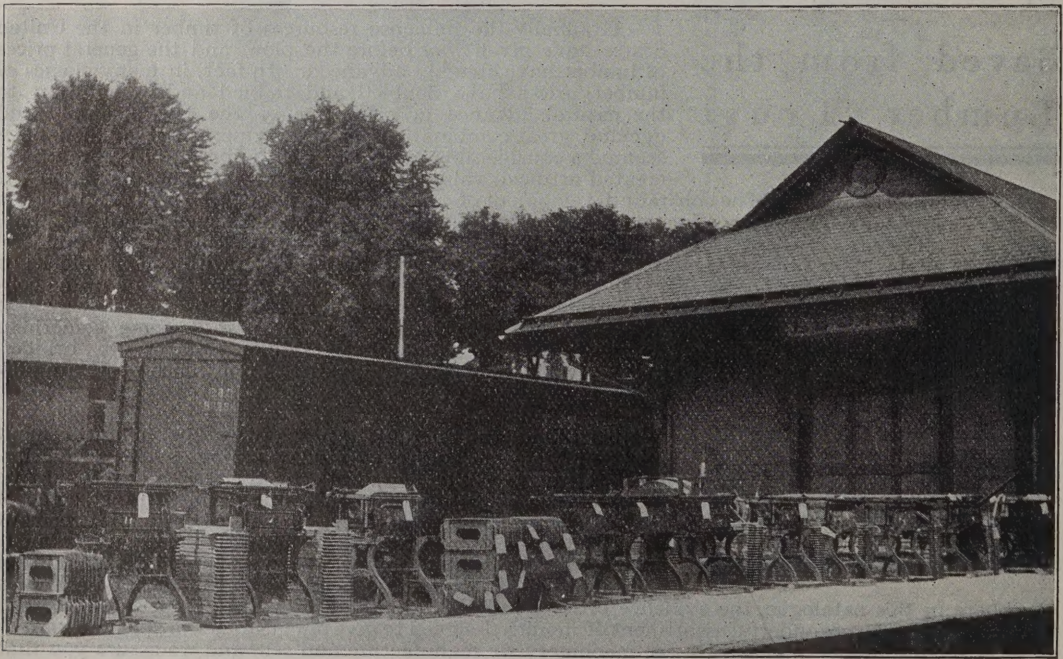
Cement Construction Justly Popular

There are innumerable reasons why the hollow cement block and cement brick of today enjoy such popularity. Cement is wonderfully adaptable for the reason that it may be moulded into almost every conceivable form. In fact, some of the architectural masterpieces of todayhave been made of cement and some of the most prominent business blocks in our larger cities owe their architectural beauty to the intelligent handling of this material. In our line of cement working machinery, as shown elsewhere in this catalogue, the evidence of its wonderful adaptability is clearly presented because herein we offer you a wonderful assortment of moulds designed to give our customers a splendid variety of faces for the blocks moulded by the machinery we manufacture and sell, and we assure you that no building material ever used is susceptible of the variety of treatment possible with cement. Not only can it be moulded into any geometric form, not only can you secure a rock face as beautiful as that which nature herself has made, but you can get an exact reproduction of the most artistic fashioning of the stone worker and the sculptor, thus producing building materials ranging from the ordinary foundation block to the most artistic cornice modeling and facade work. It is also possible to tint cement blocks and cement brick moulded in our cement working machinery any color that may be desired. The most delicate tint or the strongest coloring is possible and wonderful uniformity in color thus secured which is not found even in the granite from the world's best quarries.

Another great advantage in the use of cement in building construction lies in the fact that exterior and interior walls constructed of hollow cement blocks or cement brick reduce the fire hazard to the lowest possible minimum, making fireproof construction almost a certainty and reducing fire insurance premiums to the lowest possible figure. Still another decided advantage lies in the fact that any building constructed of hollow cement blocks has continuous air chambers from foundation to roof, making these buildings frostproof and moistureproof, warm in winter and cool in summer. The expense of heating a building constructed of cement blocks or cement brick is less than the expense of heating a building of equal cubic contents constructed of other materials. Another advantage in the use of cement lies in the fact that painting is entirely dispensed with. When the old style clay brick is used, the elements sooner or later discolor this material. Furthermore, the brick used may come from several kilns and vary in color and quality. After a few years most owners of brick buildings find it desirable, and in many cases necessary, to cover them with a mineral paint. Frame structures must be painted and the life of wooden buildings depends largely on the qualities of the materials used in painting and the care taken to keep them well protected from the weather by frequent repainting. It is expensive to paint the average building and all this is saved to the owner of a building constructed of cement blocks or cement brick. Indeed, if there were no difference in the cost of a building, whether constructed from cement brick or cement blocks, or whether built of wood, or even if the frame structure cost a few hundred dollars less than the building of cement construction, it would be real economy to select cement construction because the paint bills saved in five or six years will more than make up the difference in the first cost.

Civilized man is rapidly learning the secrets of nature, and in the making of cement stone nature's methods have been duplicated. Indeed, in many of the buildings now constructed from cement the cement stone used resembles in perfection of texture the stone taken from the best quarries in the world. Not only does the manufactured stone equal in quality the stone itself, but it excels in uniformity of color, it is much lighter in weight, it possesses greater strength, the cost is less, it is almost waterproof and is as suitable for the palaces of the rich as it is for the foundations of the homes of the poor.

To sum up in a few brief words, the use of cement is more satisfactory than the use of any other building material because it will last forever; it may be handled by the inexperienced, any mason can place this material in the wall, it is adaptable and may be moulded into any form, it is fireproof, moistureproof and frostproof, it is the cheapest building material of today and will give the most satisfactory service under all conditions.



This Illustration is from a Photograph Taken of the B. & O. R. R. Freight House at Our Factory in Central Ohio, the Home of the Buckeye Cement Block Machines, One Morning Last Summer, Showing a Morning Delivery of Outgoing Buckeye Machines Just Before Being Loaded Into Freight Cars.

PROFITS IN THE BUSINESS

THE business of manufacturing cement blocks and cement brick is exceedingly profitable at the present time. Indeed, the demand for this building material is now only in its infancy. As other building materials continue to advance in price, which, of course, will be the case, especially in lumber, as the supply is diminishing very rapidly and there is no prospect of improved conditions, the use of cement will double and treble as the years go by. While the manufacture of cement blocks and cement brick is what might be termed a new industry, it is in no sense an experiment, as thousands of buildings, ranging in cost from a few hundred dollars to many thousands, have been erected with this material. There will be improvements in cement working machinery and methods from time to time, as is always the case in every industry, but such improvements will only increase the general use of cement blocks and cement brick and will still further enlarge the demand for this material. Anyone of any mechanical turn of mind can make money in this new and attractive business. The demand already exists and it is simply a question of supplying it with cement blocks and cement brick of good quality.

As in all other lines of business, those who start the business first are the ones who make the most money out of it. Those who start now and establish a reputation for making good blocks and good brick will build up a patronage that will pay them a handsome profit for years to come. There is not the slightest doubt that cement blocks and cement brick will be the general building material of the future. The very best authorities, those who are most competent to venture an opinion, say that the business is now in its infancy and that cement will be the cheapest building material of tomorrow. In many localities contractors now specify a lower price for cement block and cement brick buildings than for those made of wood. There seems to be no limit to the demand, no limit to the possibilities of this business.

CEMENT AS A BUILDING MATERIAL

One of the leading trade magazines, in dealing with the subject of the enormous output of cement, says:

"In the building of foundations and thick walls concrete is coming more and more into use. It takes the place of the more costly brick and stone. Moreover, when cement is mixed with broken stone in the right proportions, the resulting structure is better than one of stone or brick, because of its solidity, lack of joints and homogeneity. In fact, these results have made the use of cement by engineers and contractors common rather than its greater economy.

"It is impossible almost to imagine, without some such illustration as the building over of the burned district in Baltimore or the rejuvenation of San Francisco and Valparaiso, what will be the consumption of Portland cement in the future.

"So now at a time when the forests are failing, when stone and brick and steel, as structural material, are hardly sufficient to meet the requirements, cement fills the breach and has made possible the most extensive era in building the world has ever seen. More than that, the source of cement is apparently inexhaustible.

"At the present time cement is the prop and stay of building operations. It goes into the foundations of our street pavements; it forms our sidewalks. The foundations of our large structural steel buildings are only made possible by the use of cement. We build cement houses, barns, factories, chimneys, bridges and viaducts. Our large sea-going steel vessels are lined with it."—From Cement and Engineering News Chicago, Ill.

This New Field is Open to Anyone

It is not necessary for you to have had experience to enter this business and make a splendid success of it. It requires but very little time to acquire the experience necessary to produce a strictly first class cement block and a strictly first class cement brick. There is no mystery whatever about Portland cement and the making of cement blocks and cement brick, the necessities being first class machinery and good materials. The machinery we supply, as catalogued in the pages of this Special Cement Working Machinery Catalogue, and at prices ranging from one-third to one-half those asked for machines which do not compare with ours, while materials of the very best qualities are to be found in every community. Farmers who own a sand bank or a gravel pit can manufacture cement building blocks and find a large sale for them at a very handsome profit. Lumber dealers are purchasing our machines and beginning the manufacture of cement blocks and cement brick and find it a very profitable side line for them to handle. Contractors and builders find it is profitable for them to make cement blocks and cement brick for their own use and for sale in their community. The cost of cement blocks and cement brick will vary according to the prices you have to pay in your local community for the cement and other materials which you use in your manufacturing operations. In a great majority of communities in the United States 5 cents' worth of cement will make a block 8x8x16 inches, which is the standard size. The price at which blocks of this size are sold ranges from 15 cents to 25 cents each. A great many builders claim that at 25 cents each cement blocks are cheaper to build with than the old style clay brick at $6.00 per thousand; but even at prices averaging 20 cents each, which is the common price, the profits in the manufacture of cement blocks are very attractive indeed. To build up a permanent business in cement blocks it is essential that you have machinery that will make strictly first class blocks and make them economically. This our machines are guaranteed to do. It is also essential that all the materials be thoroughly mixed, and it is also necessary that the blocks be well cured after they are made. To make a first class cement block, make the face from a mixture containing one part cement and two or three parts of sharp sand or finely crushed and screened stone. This face should be from one-half to three-fourths inches thick. The material for the body of the block is made with one part cement and five to six parts of sand, and crushed stone or gravel. This material should be thoroughly mixed when dry and not moistened until ready to mould, and then it should only receive moisture enough to make moulding and tamping easy. It should not be too dry because it will crumble, and if too wet the block will fall down. Just the right degree will come to you quickly, so that you will have no trouble at all. All the material must be solidly tamped into the machine. The block should then be removed by means of the pallet and it should remain on the pallet just as it comes from the machine until it is thoroughly set; generally twelve to twenty-four hours. As soon as the block has set it should be thoroughly sprinkled and kept wet for not less than forty-eight hours. This sprinkling should be done at least twice a day or often enough to keep the blocks wet all the time. This is really the most important point in the manufacture of good blocks. No matter how good the material, no matter how carefully made, no matter how perfect the machine may be, unless the blocks are properly cured they will not last. Cement blocks can be used in building operations within thirty days after being made.

This in brief is an outline of the handling necessary in making cement blocks and cement brick. It is very simple, and you cannot possibly fail to succeed when you purchase a machine from us because our directions are very complete, very explicit and very easily understood, giving in detail the method of mixing the raw materials, and a day's experience will qualify you to produce a perfect block or brick.

Small Capital Will Start this Business

We do not know of a single line of business anywhere, yielding the profits which the manufacture of cement blocks and cement brick will yield in any community, that may be undertaken with as small capital as that required to establish a cement block or cement brick making business. This is especially true if you purchase your cement working machinery and accessories from us through the pages of this catalogue, because the prices we charge on this highest grade machinery and accessories are from one-third to one-half the prices charged by other manufacturers and dealers for machinery and accessories which do not begin to compare with ours in quality, in durability, in simplicity and productiveness. A cement block machine or cement brick machine and mixer and a few accessories will enable you to enter upon this business with a very complete equipment and one which will set you up in business so that you will realize handsome profits from the day your machinery is placed in operation. A mechanic with $100.00 capital may embark in this business in the confident belief that it will be a big success. One of our X-L-ALL Cement Block Machines, the highest grade block machine made, together with a mixer and some other accessories may be purchased for approximately $100.00. If you care to mix the materials by hand to begin with and purchase the X-L-ALL Cement Block Machine with a few accessories, it is possible for you to begin the manufacture of cement blocks with a smaller capital than $100.00. If, however, you can afford to invest more money, if you can afford to buy the X-L-ALL machine with the finest line of accessories, a brick machine and a mixer, you will then have an equipment which will enable you to handle a large volume of business every day and increase your profits to a greater degree. If you will investigate this business you will be convinced of its great possibilities for profits and we feel sure that in your own community you will find an ample field for the building up of a permanent and satisfactory business.

The United States Government has made a very complete investigation of the uses to which cement may be put and the Department of Agriculture has issued a bulletin on this subject which will give a vast amount of information to anyone interested in this subject. Just write a letter to the United States Department of Agriculture, Washington, D. C., and ask them to send you Farmer's Bulletin No. 235, and it will be sent to you FREE.

A CUSTOMER ACHIEVES GREAT SUCCESS

We reproduce photograph sent us by a customer who is using four of our Buckeye Cement Block Machines. This photograph was sent us to show the wide range of work which this customer is doing on his line of Buckeye Cement Block Machines and Buckeye Column Moulds. Here is a block for every job of work. This yard turns out Buckeye Hollow Cement Blocks 8, 10 and 12 inches thick and 16 inches long, and he also has the Ohio Combination Cap, Sill and Block Machine, which enables him to turn out blocks 8x8x24 inches and caps and sills from 10 to 14 inches wide and from 2 feet up to 4 feet in length. This yard produces every size and shape of both hollow and solid concrete building blocks to suit the requirements of every carpenter, contractor and builder.

Machinery Which Does The Work

IN offering you the cement working machinery and accessories shown in the pages of this special catalogue, we are offering you the very highest type of machinery designed for a special purpose which has ever been offered the contractor and builder or the cement worker. We have not gone about the development of cement block and cement brick making machinery in any haphazard manner, but instead have done a very large part toward the development of perfect machinery for the making of these blocks and brick. Before we offered a machine of any kind we spent a great deal of time investigating the different styles of machines on the market, trying them out in our own way and discovering the defects, if any, the strong features, if any, laboring constantly with the idea of producing such machinery and accessories as would be reasonable in cost, simple in operation, and so thoroughly well made as to be practically indestructible, and so simply constructed as to be impossible for them to get out of order beyond the ability of the ordinary mechanic to correct. In these experiments we also tried all the different methods of manufacturing blocks and brick practised in various localities, we used all the various materials and combinations recommended by cement workers, and as a result of these experiments we developed a line of concrete working machinery and accessories now offered in the pages of this catalogue, and in offering them to you we say without hesitation that the machines we sell cannot be equaled by any other manufacturer or dealer, our machinery representing the very highest type developed in the manufacture of cement block and cement brick machines, concrete mixers and accessories. During the past year we have placed in the hands of our customers upward of one thousand cement block machines and these machines are giving universal satisfaction; they have proved wonderfully productive in the hands of inexperienced men; the claims we made for this machinery and all the claims we set forth in this catalogue have been justified by the experience of the thousand or more users within recent months.

In the development of our cement working machines we have made wonderful strides. In our X-L-ALL and Buckeye Machines we offer machines capable of adaptation to three sizes of blocks, 12 inches wide, 10 inches wide and 8 inches wide. These machines will provide blocks 12 inches wide, suitable for foundation work strong enough to carry three and four stories, a block 10 inches wide for the first story and the regulation 8x8x16-inch block for the upper stories. No such machines as these are offered by any other dealer or individual and we are undoubtedly so far in advance of the general manufacturers of cement block machines and accessories that it will be some years before these machines of ours will be equaled in adaptability or all around value. We have felt from the very beginning that the perfect cement block machine would be that machine which was most adaptable to the varied requirements of contractors and builders, and which combined high class workmanship and materials with simplicity and productiveness, and in these particulars the cement block machines catalogued in these pages are far in advance of the machines offered by others, even at prices several times those asked by us.

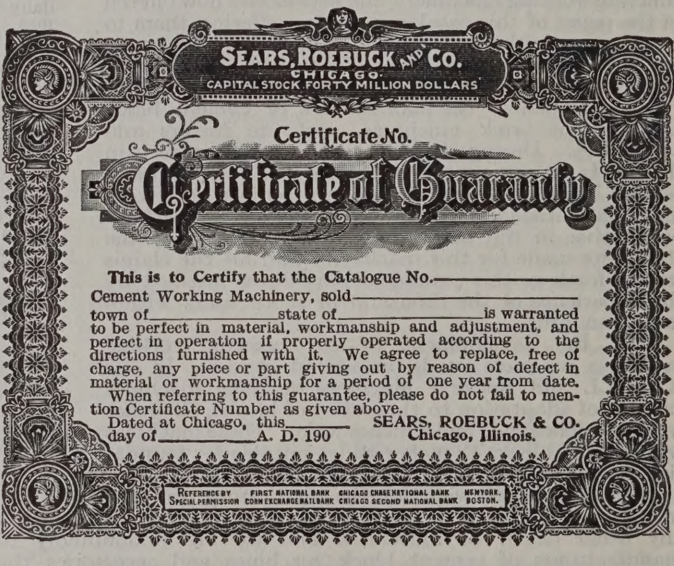
CEMENT BUILDING BLOCK INDUSTRY

"Cement building block construction has struck the masses throughout this broad land. We are receiving daily visits and letters from all sorts and conditions of men, asking for clear facts on the subject of cement building blocks, particularly as to the comparative cost of brick and these blocks, as well as to their durability. 'Will they last, and would you advise their use?' So run the inquiries. Architects inform us that their clients are likewise seeking definite information on the subject, while the daily press throughout the country is full of items in praise of concrete building blocks, predicting that they will displace brick, stone and wood in the near future. From every point of view the cement building block industry is extremely flattering. Great corporations have been formed to place these blocks upon the market, some having $100,000 capital, while numerous smaller companies and individual manufacturers are scattered from the Atlantic to the Pacific, as well as from the Gulf to our Northern borders. The one remarkable fact stands out clear and prominent—that all are doing a thriving, prosperous business. In the smaller communities the cement block manufacturer is looked upon as a public benefactor; the local newspaper gives him numerous free notices and comments upon his great enterprise, all of which bring him new customers. This avocation is, therefore, extremely pleasant as well as profitable. Our advice is, 'Go into the cement block manufacturing business if you want to make money and create pleasant surroundings.' "—Cement and Engineering News, Chicago, Ill.

The Prices Quoted by Us are Very Low

Not only have we produced the highest type of cement block machinery adapted to the making of several styles and sizes of blocks, not only have we succeeded in producing machines which are so simple that it is practically impossible for them to get out of order, and designed along such lines that they are extremely productive machines, giving maximum results at a minimum labor cost, but, manufacturing these machines in a foundry controlled by us and in enormous quantities and, furthermore, not being dependent on the profits the sale of cement working machinery yields us, we quote prices which, in comparison with those asked by others, are astonishingly low. In many cases the prices quoted by us in the pages of this special catalogue are from one-third to one-half the prices asked for the machines sold by others.

A great many manufacturers seem to be taking advantage of the general lack of information on this new industry and are asking exorbitant prices for machines manufactured by them, prices which mean to these manufacturers very large and unreasonable profits. As we have said elsewhere in this catalogue, there is absolutely no mystery about Portland cement and no mystery about the making of cement blocks and cement brick. Any average man can succeed with any of the machines offered in the pages of this book; and why manufacturers should throw about this industry an air of mystery, and by these methods endeavor to justify the exorbitant prices they ask for very ordinary machines, we have not been able to understand. Furthermore, we sell cement working machinery outright; we have no county rights to offer you, we do not ask for royalties on the blocks and brick manufactured by you, as many other manufacturers do. There are no strings whatever tied to the machinery purchased from us, and in this respect our methods are at variance with the methods of many manufacturers of cement working machinery. If you have seen a catalogue of other cement working machinery and accessories and you will compare the machines therein offered with the machines catalogued in these pages, you will notice very quickly the great difference in the quality of the machines offered by us and the machines offered by others and you will note the decided advantages in design, in simplicity and adaptability of our machinery as compared with theirs, but above all else you will notice a wonderful and a wide difference in the prices in our favor. The agent or representative of the other manufacturer will undoubtedly endeavor to convince you that we cannot offer you a superior machine at the low prices quoted by us, but we ask you not to be misled by any argument which may be presented to you to influence you against us or our machines, because we are perfectly willing to let the machine itself stand on its own merits. As explained elsewhere in this catalogue, we are perfectly willing to send any of the machinery shown in these pages on a thirty-day free trial so that you may try it out yourself in your own way. No manufacturer or dealer we know of makes any such proposition as this, so that while our prices are extremely low, they are prices which are reasonable and should not lead you to believe that our qualities are not of the very highest. You have it within your power to prove the truth or falsity of the claims we make and we ask that, before placing an order with any other firm or individual, you first send to us for a machine which will do the work required by you and give it a thorough trial under our thirty-day free trial offer, as explained on page 9.



SEARS, ROEBUCK AND CO.
CHICAGO.
CAPITAL STOCK FORTY MILLION DOLLARS

Certificate No.

Certificate of Guaranty

This is to Certify that the Catalogue No.__________
Cement Working Machinery, sold__________
town of__________state of__________is warranted to be perfect in material, workmanship and adjustment, and perfect in operation if properly operated according to the directions furnished with it. We agree to replace, free of charge, any piece or part giving out by reason of defect in material or workmanship for a period of one year from date.

When referring to this guarantee, please do not fail to mention Certificate Number as given above.

Dated at Chicago, this__________
day of__________A. D. 190

SEARS, ROEBUCK & CO.
Chicago, Illinois.

REFERENCE BY SPECIAL PERMISSION FIRST NATIONAL BANK CORN EXCHANGE NATL BANK CHICAGO CHASE NATIONAL BANK CHICAGO SECOND NATIONAL BANK NEW YORK. BOSTON.

Reasons Why Our Prices are so Low

The reason most cement block machinery is sold at a very high price lies in the fact that manufacturers dealing in this class of machinery alone find it necessary to make a very extensive advertising campaign by the use of expensive advertising mediums, the payment of large commissions to agents, besides salaries to salesmen, traveling expenses, exhibitions at fairs, etc. These big expenses must be paid by the purchaser of cement working machinery sold by other dealers. Every one of these expenses is entirely eliminated by us.

The cement working machinery shown in the pages of this special catalogue **is not sold through the old cumbersome retailing methods** which involve the payment of profits and commissions and expenses to a number of middlemen. If the manufacturer charges his actual cost and then adds an additional percentage to cover his profits and his commissions to agents and salesmen, naturally it will not require many additions of this character to double the first cost of the machinery. If we manufactured and sold the cement working machinery shown in these pages in this manner, we too would be compelled to ask probably two or three times the prices named in this catalogue. Instead, we have these machines manufactured for us in the largest and best equipped iron working plant in this country, and to this low manufacturing cost we add only our one small margin of profit, a mere fraction of what the average dealer must get in order to succeed in business. We have no agents, no salesmen, and the only advertising expense is that involved in the printing of our catalogues. This will explain to you why our cost is less than the cost of other manufacturers, why we can offer you these astonishingly low prices and yet give you machines better than those sold by others.

Naturally, as we do such a large volume of business, a business which has grown to be very much larger than all the other mail order houses in Chicago put together, we depend entirely on the large number of our sales for our aggregate profit, and a very few cents on an article, a profit so small that it would bankrupt the ordinary merchandising institution, is a sufficient profit for us and enables us to undersell any other merchandising institution in the world. The cement working machinery sold by us is made by the largest and most reliable manufacturers of high class machinery of this kind, men who through years of experience have become past masters in the iron working industry, and with the most up to date facilities, with perfect labor saving machinery and the employment of skilled labor, have reduced the cost of manufacture to the lowest possible minimum; and we guarantee that the machines produced by us are of the very highest quality and guarantee them to be the equal of any cement working machinery offered by any other manufacturer in the world and much lower in price. Turn to page 8 and read our certificate of guarantee which we send with every machine sold by us.

Our Broad and Very Liberal Guarantee

Every cement working machine, part or accessory, illustrated, described and priced in the pages of this special catalogue, is guaranteed to be exactly as described and to do perfect work. We guarantee every machine to be thoroughly well made of first class materials, and finished in a workmanlike manner and to do the work for which it is intended when handled according to directions.

We guarantee our machines equal to any cement working machinery made by any firm or individual. We guarantee our cement block machines and our cement brick machines to make as true and as perfect blocks and brick as any machines ever made. We guarantee that you will be perfectly satisfied with any machinery purchased from us, and if after thirty days' free trial, as explained on this page, any machine purchased from us is not entirely satisfactory in every respect, it is your privilege to return it to our factory and we will refund your money, and the transportation charges.

Guaranteeing the quality of the material and the workmanship in our cement working machinery, if any defect, either in material or workmanship, or any break caused by any defect in any part of the machine appears within a year from date of shipment, we will promptly supply you with new parts to take the place of the defective or broken parts without expense to you, and we will prepay the transportation charges on the new parts. We know we have a superior line of cement working machinery, the very best line on the market today, and we are willing to stand behind them with all the resources of this great commercial institution, and on our guarantee of quality, our guarantee of simplicity, our guarantee of perfect satisfaction or your money back and the transportation charges both ways, we solicit your order for any of the machinery or accessories shown in the pages of this special catalogue.

Our Very Liberal Terms of Shipment

We offer all cement working machinery and accessories under the very broadest terms possible and we are so sure of the high qualities of everything catalogued in these pages, and we are so certain that the prices are very much lower than the prices quoted by others on machines and accessories not nearly so good as those offered by us, that we can well afford to say to you and all those who have never ordered merchandise from us that we stand behind every article catalogued in these pages and are willing to ship the goods to you on the most liberal conditions. Understand that our guarantee covers everything shown in these pages, and no matter what you order we guarantee that you will be perfectly satisfied with it or you are under no obligation to keep it.

Our Thirty Days' Free Trial Offer

As an earnest of our supreme confidence in every cement working machine catalogued in these pages, as a guarantee of all the claims we make for these machines and outfits, we are willing to ship any outfit selected from the pages of this special catalogue with the distinct understanding and agreement that you may use the machinery and materials purchased from us for thirty days, and if after using the outfit in your own way under conditions as they exist with you, if you do not find that every claim we have made has been more than substantiated, if you do not feel that you have received greater value in the machinery and accessories ordered from us than you could secure from any other firm or individual at home or elsewhere, if comparison with other machines and accessories does not convince you that our machinery is better made, is stronger, simpler, less liable to get out of order and in every way strictly first class, and the best at any price, you are at liberty to return the machinery and accessories to us, we will refund the money you sent us and we will reimburse you for the transportation charges paid by you. No other firm or individual offers you any such proposition as this and we do not know of any method we could adopt to give you stronger proof of the merits of our cement working machinery than this thirty days' free trial offer. We do not qualify this offer in any way whatsoever. We have no salesmen, no representatives on the ground to urge the merits of our machines, simply depending on the machinery itself and your good judgment after a fair trial to make a friend and customer of you. The machinery itself is so high grade, it is so easily operated, it is so simple that it does not get out of order; our directions are so full and complete and so easily understood that we know you will not have the slightest trouble in operating it to your own satisfaction, and for these reasons we are glad to make this liberal thirty days' free trial offer to give you every opportunity to satisfy yourself that all our claims are true.

About Our Wonderfully Low Prices

The prices quoted in this Special Catalogue of Cement Working Machinery and Accessories are not subject to any discount whatever. We make no price concessions to dealers, contractors or individuals, no matter whether they buy one or one thousand machines. Our methods of pricing merchandise are not the methods followed by any other firm or individual and our original policies along these lines are responsible for the enormous volume of business now enjoyed by this house. We have made very large contracts for all the merchandise shown in this special catalogue and we offer these machines and accessories to our customers at the mere cost of materials and labor with one small percentage of profit added. We sell these goods at a lower price than any other cement working machinery can be offered, and as this department of our business is only one of sixty-five merchandising departments, we are therefore not depending on one line of merchandise for our aggregate profits, and for this reason it will be readily understood by you why we can be satisfied with a smaller margin of profit than any other manufacturer or dealer in cement working machinery who is dependent on this line alone for his profits. Our margin is already so small that we cannot possibly further reduce our prices.

We have no agents, because under our method of selling we could not pay commissions of any sort. Sometimes our customers solicit orders from their friends and neighbors, but they do so solely to secure the Profit Sharing Certificates which are issued in the name of the customer to whom the goods are shipped, and these Profit Sharing Certificates, which may be exchanged for many valuable articles free, represent the only interest they have in securing orders from their friends and neighbors.

Why We Ship Orders From Our Factory

All of the concrete machinery and accessories illustrated, described and priced in the pages of this special catalogue are shipped direct from our factories and the customer pays the transportation charges from the factory to his nearest railroad station. Shipments of cement working machinery are made from our factories entirely in your interest, for in so doing we save local freight charges, drayage, storage, etc., which all other manufacturers and dealers in cement working machinery are compelled to add to the cost of their machines if sold by agents or dealers or shipped from general warehouses instead of from their factories. Together with the descriptions of the machinery and accessories catalogued in these pages, we indicate the points from which the machinery will be shipped, also the weight of each article when prepared for shipment, so that you may very easily ascertain the exact freight charges from the factory to your station. Should you order tools or other supplies shown in our Big General Merchandise Catalogue and which are to be shipped from our Chicago store, do not expect to receive the entire order in one shipment, as the shipment of cement working machinery will be made from our factories, as indicated in these pages, while all the supplies ordered from our Chicago store will be sent to you in a separate shipment from Chicago. It is absolutely impossible for us to ship tools, hardware and other merchandise with the machinery and tools shown in this Special Cement Working Machinery Catalogue. It has been our policy always to make shipments by the most direct and most economical route and transportation company, so that our customers will receive the merchandise sold by us at the lowest possible net cost to them. We have found in twelve years' business experience that the most economical method for us to follow is to send our bulkier merchandise direct from our factories to our customers, thus saving all the handling, cartage, extra freight charges, etc., necessary where the merchandise is first sent from the factory to the store at Chicago and then shipped to the customer. For the purpose of reducing the cost of merchandise handled by us to the lowest possible figure, we maintain one of the largest traffic departments connected with any mercantile institution in the world, and it is the sole business of the employes in this department to handle our customers' orders and plan our shipments so that every penny of transportation possible to be saved will be saved to our customers.

We Will Make Prompt Shipments

Of course, we understand that carpenters, contractors, builders and all others who order cement working machinery do so because they are in immediate need of the machinery or accessories ordered, and we are especially cognizant of the fact that contractors and builders are extremely busy at certain seasons of the year and delays of any sort in the receipt of material or supplies ordered by them are very annoying and very expensive, especially when contract work is well under way. That we might be ready to fill their orders in the shortest possible space of time, we have specially prepared to handle a very large volume of business in concrete working machinery and have anticipated our wants so far in advance that we can make prompt shipment of the outfits described in the pages of this catalogue and are at all times prepared to get out special outfits and equipments such as circle blocks and other styles of faces and plates on the very shortest notice. All correspondence addressed to us on the subject of concrete working machinery will be given our prompt and best attention and we are ready to give you any information asked for by return mail.

We cannot too strongly emphasize our ability to handle your business quickly, because this is of very great importance to you we know. We have a corps of men experienced in all lines of cement construction, men who are thoroughly well posted in every feature of the cement block and cement brick machine business, and they will attend to your orders and letters personally and see that you receive prompt and accurate information and that your orders are carefully, intelligently and promptly handled. We have unlimited facilities in the very best factories in which to manufacture this class of machinery, and these facilities not only enable us to give our customers the very highest grade machinery, promptly, at extremely low prices, but also enable us to manufacture new devices and constantly improve our lines of machines from time to time as improvements and new ideas develop. Youwill understand that the cement block and brick machine business is comparativelya new business, and while our machines are fully up to date, are as perfect as money and labor can build and are far in advance of any of the machines now on the market, we are continually bringing forth new devices, we are constantly developing new ideas in the cement machinery business which we intend to work out and apply to our line of machines from time to time as their practicability is demonstrated, and the wealth of information which we are gaining from week to week and month to month in the manufacture of this machinery and from our experiments will be freely given to our friends and customers upon request. It is with this thought in mind that we say to you that we shall be very glad to answer your inquiries and to do all that we can to give you an intelligent understanding of this new and rapidly growing business to the end that your profits may be largely increased. This feature of our business, we feel, will be worth a very considerable amount to every contractor or builder or individual who embarks in the manufacture of cement blocks or cement brick, and especially valuable will it be to those who purchase our splendid, up to date and unequaled cement working machinery.

We Guarantee Safe Arrival, Your Station

We guarantee every cement working machine and every part or accessory as catalogued in the pages of this special catalogue to reach you safely and in good order. It is very seldom indeed that we incur any loss or breakage while the goods are in transit, because we use care in packing all our machinery and supplies and every shipment is checked and rechecked before being delivered on board the cars. All the extra parts in each cement working machine are removed and boxed to avoid any possibility of shortage or damage while in transit. However, should it happen that any machine or any portion of a shipment should reach you with any part damaged or broken, or should the transportation company fail to deliver to you the number of items or bundles as specified on the duplicate freight receipt which we will mail to you on the date we make shipment of your order, we ask that you accept the shipment from the transportation company, but be sure to have your local freight agent write the facts concerning the breakage or shortage on the face of the freight receipt which the agent will give you when you pay the transportation charges. It is very important that you ask the agent to write these facts on your freight bill and sign his name to the statement; send this receipt to us with a letter giving us information that will enable us to tell exactly what part or parts are broken or missing, and we will at once send new parts to you free with all transportation charges prepaid.

When we make shipment to your order, we send you a duplicate shipping receipt that is a copy of the original receipt we receive from the transportation company and you should retain this duplicate receipt until the shipment reaches you so that you can check up the goods you receive against the list of goods shown on the shipping receipt and be absolutely certain that you have received all of the goods that belong to you. We urge you to examine your machine carefully when it reaches your nearest railroad station and satisfy yourself that it is in good condition. Every casting and every part of the machine we sell bears a repair number, and in case of damage in transit it is not necessary that you return the broken or damaged part to us, just give us the number cast on the broken parts, attach the freight bill with the agent's notation thereon showing damaged condition, as explained above, and we will forward the new parts to you at once.

Remember, therefore, that we guarantee safe delivery and will protect you from any loss or damage in transit, only asking that you help us by examining the outfit carefully before you accept it to discover whether any damage has been done to the machinery while in the hands of the transportation company, and in case you do find damage, follow our instructions as outlined above so that we may take the matter up with the railroad company and adjust the matter without any annoyance to you.

While we carry a large stock of machines on hand at our different factories and have anticipated our orders as far ahead as it is possible for us to do, and while we are able to fill your order almost the same day it is received, nevertheless, we ask you to remember that goods sent by freight require a reasonable length of time to reach their destination, and, therefore, do not get impatient if the goods ordered do not arrive within a very few days after you have sent your order to us. Always allow from one to five days for your order to reach us and to be transferred to our factory for shipment, and if there is any reason why we cannot ship your order promptly, we will always advise you at once and tell you on just what date shipment can be made, but if you do not hear from us within a week from the time your order is mailed us, you will understand that we are making prompt shipment and that the railroad company will deliver the goods to you in a very few days' time, depending, of course, on the distance you live from the point of shipment.

Freight Charges on Cement Machinery

All prices quoted in this catalogue are for the machinery or accessories delivered, securely packed, free on board the cars at our factory, from which point the customer pays the freight. The freight charges on our cement working machinery and accessories will be comparatively low. If you will refer to page 153 in this catalogue you will find a table of freight rates showing rate per 100 pounds to several cities in every state and territory in the Union. From this table of information you will be enabled to figure the approximate freight charge on any kind of an outfit you may order from us.

We give the approximate shipping weight of every outfit and every part or accessory catalogued in the pages of this special catalogue, and these weights you will find placed opposite the item named, and it will be possible for you to estimate the freight charges on your shipment. Find the city in your state which is nearest to you, multiply the rate to that city by the weight as given with the article or articles which will make up your shipment and this will tell you with reasonable certainty what the freight charges will be to your nearest railroad station. There are, however, some variations in the weight of goods, some variations in the material used in packing from time to time. The weights given in this catalogue are approximately correct and by using them as a basis, together with the freight rate to the city or town which is located nearest you, will give you within a very few cents what the transportation charges will be to your nearest railroad station.

In any event the freight charges on any of the machinery or accessories shown in the pages of this special catalogue will be but a mere fraction of the big saving we make for you over the prices asked by any other firm or individual on cement working machinery, parts and accessories. Just ask for quotations from other firms and individuals making or selling cement working machinery and accessories and compare them with the prices quoted in this catalogue and you will be astonished at the great saving we will make for you if you purchase your outfit and supplies from us, and you will discover that the freight charges are indeed a small item when compared with the difference in cost.

If you have no railroad agent at your nearest railroad station the freight charges must be prepaid. If there is no agent at your station be sure to allow a sum sufficient to cover the freight charges, and if you send us more than the amount we are required to pay the transportation company we will immediately refund the difference to you. If you have a freight agent at your station it will not be necessary for you to send money to prepay the charges, as you will find that the charges are exactly the same whether paid by you after the goods are received or whether paid by us in advance and it will frequently save delay in handling the order if you will allow us to ship the goods to you with the freight charges to be paid when received. For this reason we would much prefer that our customers do not send us money to prepay freight charges except in case there is no local agent at their nearest railroad station.

To Order Cement Working Machinery

Please use the order blank enclosed with this catalogue, although if this blank has been mislaid, just write your order on any plain piece of paper, give the catalogue number of each article in full, state plainly how much money you enclose and in what form, whether postoffice money order, which you get at the postoffice, express money order, which you get at the express office, or a draft, which you get at any bank; state how you want the goods shipped, be sure to give your shipping point if it is different from your postoffice, sign your name, postoffice, street and number, or rural route number, if you live on a rural route, plainly and in full.

We advise all our customers to send cash in full with their orders because it saves the cost of returning money to us, a charge which banks and express companies always make against you on C. O. D. shipments. When you send cash in full it enables us to handle your order with less delay and saves you the trouble of hunting up the bank or express company holding sight draft or bill of lading before you can receive the goods.

While nearly all our customers send cash in full with their orders instead of having the goods shipped C. O. D., and we earnestly recommend that cash in full be sent with your order, we will accommodate those who do not care to send the full amount of money with their order and will ship any outfit shown in the pages of this catalogue to any point east of the Rocky Mountains on receipt of a deposit of $5.00, the balance and freight charges to be paid at the railroad station when the goods are examined and found in good condition. Please remember that when you send cash in full with your order you have exactly the same privileges that you would have if the goods were sent C. O. D., because we give you the same thirty days' free trial, we send the machinery and accessories to you with the full understanding and agreement that all must arrive in good condition, must be perfectly satisfactory in every respect or the shipment may be returned and we will refund the money in full and pay the transportation charges. It is therefore very much to your advantage to send cash in full, although if you have any doubt as to the quality of the machine and the claims we make for it, we will, of course, be glad to accept your order on the C. O. D. basis.

Is It Safe to Send Us Your Orders?

You are perfectly safe in sending us your orders and your money. We are one of the largest commercial institutions in the world and we occupy by far the largest mercantile plant in the world. We own this entire plant, comprising forty acres of ground in one of the best districts in Chicago, free of indebtedness of any kind; our ground and buildings alone are valued at more than six million dollars. We have nearly nine thousand employes and our customers now number nearly five million. If you have any doubt, you are at liberty to refer to any bank, business house or resident of Chicago, and we especially refer to our millions of satisfied customers. Ask your neighbor about Sears, Roebuck & Co. We have customers in every neighborhood in the United States, and gladly refer you to any customer.

Be sure to read the bank letter of the First National Bank of Chicago, capital and surplus, $13,000,000.00, signed by its cashier, F. O. Wetmore; also the Corn Exchange National Bank letter, capital and surplus, $6,000,000.00, signed by Frank W. Smith, its cashier; consider our standing everywhere and be convinced it is perfectly safe to send your money to us, we agreeing to return it if the goods do not please you.

Don't Be Misled by Unfriendly Dealers

If any dealer or agent of other cement working machinery tells you that it is not safe for you to order cement block machines, cement brick machines or concrete mixers from us (and he may tell you this because he cannot compete with us either in quality or prices of his machinery and accessories), just remember our guarantee, our liberal thirty days' free trial offer, our financial responsibility, and our willingness to return your money if you are not perfectly satisfied in every way. Send us your order and when the machine reaches you give it thirty days' trial in your own way, and if you do not find it perfectly satisfactory you may return the machine to us at our expense. Just ask the other agent or dealer whether he will let you have one of his machines on the same liberal terms, ask him whether you may set it up side by side with a machine ordered from us and ask him if he will permit you to submit it to exactly the same test; ask him if he will let the machinery stand on its own merits; ask him if he will let you work it yourself so that you can discover its ease of operation, its simplicity and durability to alone influence you in your final decision between his machine and ours.

Ask your neighbors and friends about Sears, Roebuck & Co., their methods of doing business, their liberal free trial offers, and then remember that our liberal terms apply to all our cement working machinery and that you are at liberty to take full advantage of them. Don't let others unable to compete with us influence you to place an order with them until you have first sent to us for a machine designed to do the work you require, because the machine itself will do the talking for us and will convince you there is nothing that will equal it in value and real merit.

AFTER 20 YEARS' EXPERIENCE WITH CEMENT THIS CUSTOMER CHOOSES A BUCKEYE CEMENT BLOCK MACHINE IN PREFERENCE TO ANY OTHER.

1715 E. Reynolds St., Springfield, Ill., June 23, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—Yours received and contents noted. I have been very busy with the Buckeye Cement Block Machine and now I can answer your letter thoroughly, and maybe it will be of some service to you and your customers.

In regard to price, I will say I saved $106.25, as the ———— machine, made in ————, is the cheapest face tamping machine, and it sells for $125.00. It is an 8x8x16-inch, the same size as the Buckeye machine that I purchased of your company for $18.75, and it makes the same blocks.

Now, as to the blocks that I have made on your machine, I will tell you for the benefit of others that may not know about making cement blocks or handling them.

For foundation blocks I use one barrel of good gravel, three-quarters of a barrel of sand and one sack of cement. Mix thoroughly and wet with a sprinkler when mixing until it lumps in the hand, not too wet, and mix the wet batch thoroughly. That amount of sand and gravel will make sixteen blocks, and I leave them on the pallets in the shade for twenty-four hours, and then I take them off the pallets and lay them out in my yard on pieces of boards that are level. I sprinkle them three or four times a day for about ten days and then I stack them one upon top of another to cure and in twenty days they are ready to put in the wall, and this block will stand more weight than a 13-inch brick wall, and they won't be damp either.

Now, for outside blocks. I use a six to one mixture, a barrel of gravel, half a barrel of sand and a sack of cement for the body, and for the face I use a two and a half to one mixture, three-quarters of a barrel of sifted gravel to a sack of cement, and that will turn all the rain that will go against it in a lifetime. I mix the face mixture rather dry and tamp all together and then the face won't peel off. The tamping is the main thing in making blocks, and don't put in any rock or gravel larger than one inch and sand enough to fill all the voids in the gravel.

For partitions and inside walls I use one barrel of cinders, one barrel of sand and a sack of cement and you can plaster on that without any trouble and have a fireproof wall and save the cost of studding and lathing. It will never crack and a nail can be driven into it. I make the inside blocks 6 inches thick by putting an inch block in the face and on the back of machine.

You can plaster on any cement block by using one-third of lime in the mortar that you plaster with and two-thirds cement, say four sacks cement, two sacks lime and three barrels of sand. Wet the walls that are to be plastered before you put the mixture on it, and it will make a wall like a rock. For cornice blocks I make the style that I want out of some wood moulding and paint it, then put it in the machine and tamp up well, and I have any style that I want.

In building any house with blocks always place window and door frames in and lay blocks to them and it will save using level and the frames will be tight. Never mix up more than enough to make sixteen blocks at a time, as it will set up on you and get hard. I can make 200 blocks a day by myself in ten hours.

You may use this letter if you wish and also my name, and if I can be of any service to any of your customers, tell them to write me or you may write me as I have had twenty years' experience in handling cement and understand it thoroughly. Hoping that this letter is not too long and that it will be of some service, I am,

Yours truly, ANDREW J. GORDON.

East Norton, Mass., Dec. 18, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—The Buckeye Cement Block Machine I purchased from you is very satisfactory in every respect. Yours truly, J. G. DE COFF.

Watervliet, Mich., Dec. 10, 1906.

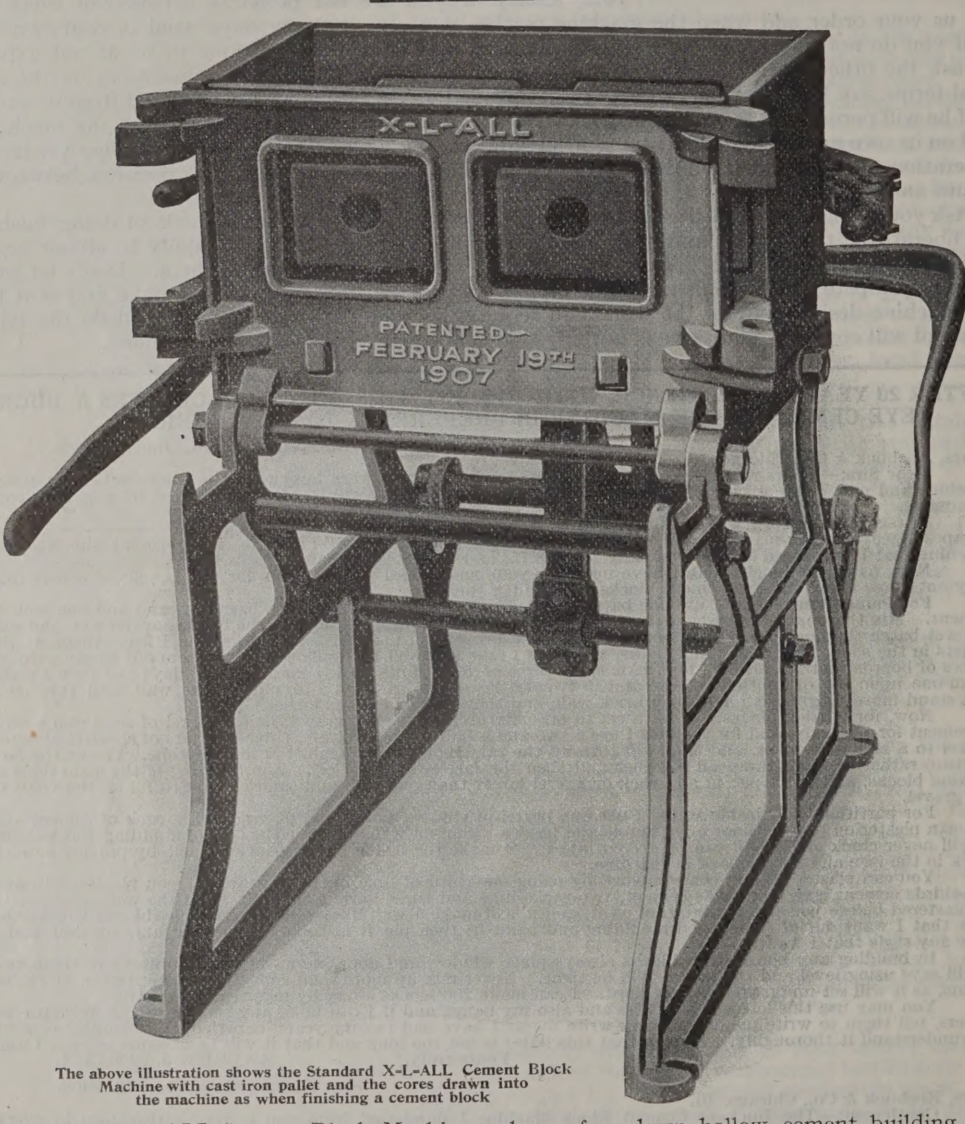
Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—Answering your request for a report on the Buckeye Cement Block Machine I received of you, will say, I am very much pleased with the machine in every respect. In regard to how it is made and works, I do not know in what way it could be improved. I have made blocks and they are first class in every respect.

I use one to six for the main part of the block and one to two for about one inch on the face of the block. I understand this is the main point of keeping the building from getting damp and by putting such a strong proportion on the face of the block will keep frost from penetrating through the block.

I am going to use the cobblestone face for the building and trim it with the broken ashler face. I am building a ten-room house, and when complete will send you a photograph. I have examined quite a number of other block machines before I sent to you for one and all the other machines made the block with the face on the side, therefore it was impossible to use two different proportions as I was instructed to by a very well informed mason who follows this business. I think by putting one and two parts for face or one and one for 1 inch, everything seasoned as it should be, there will be no reason why it will not make buildings satisfactory in every respect, and a far handsomer building than frame or brick. Yours respectfully, FRED SEEL.

Standard X-L-ALL Cement Block Machine



The above illustration shows the Standard X-L-ALL Cement Block Machine with cast iron pallet and the cores drawn into the machine as when finishing a cement block

THE X-L-ALL Cement Block Machine makes a face down hollow cement building block, 7¾x15¾ inches on the face and 7¾ inches thick, to lay 8x8x16 inches in the wall. It combines the best and most practical features in other machines, and has many advantages not found in any other. It makes the block face down, so that a better material can be used for facing. It has no complicated parts or unnecessary machinery to get out of order. No gears or cogs to fill up with cement. It is the handiest machine on the market. The location of the levers that withdraw the cores is convenient. The machine opens up so it is easy to remove the blocks. The fastenings are easy of access, all going to make this one of the fastest machines in the market.

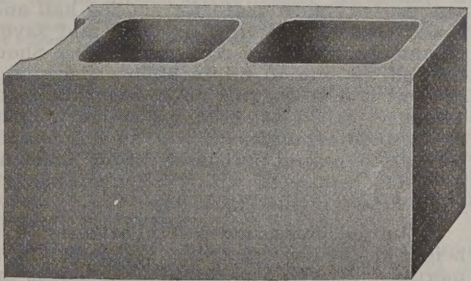
The face plates on our X-L-ALL Cement Block Machines are all made from iron patterns, planed and machined up to gauge. Every face plate is ground to fit. All parts of the machines are inspected before they leave the factory to insure that they are mechanically true and perfect.

The cores of the X-L-ALL Cement Block Machine are properly proportioned to insure the correct amount of material in every block to withstand the greatest strain to which this material will be subjected. The cores are of a proportion to reduce the amount of material used in a block without impairing its value or in any way reducing its strength A cement block 8x8x16 inches made on the X-L-ALL Cement Block Machine weighs about 48 pounds. If made with a facing consisting of one part cement and two parts sand and with the body of the block three parts sand and three parts crushed stone to one part of cement, it will require about 9 pounds of good Portland cement to make a block 8x8x16 inches. A barrel of Portland cement weighing 380 pounds will make about forty-two blocks on this basis of mixture. This calculation is based on a facing 1 inch thick.

The X-L-ALL Cement Block Machine is built along thorough mechanical lines; in other words, the material used in the construction of this machine is distributed where it is most needed to withstand the strain the machine may be subjected to. The parts which sustain the hardest usage are heavy and strong. We have spared neither workmanship nor material in the construction of the X-L-ALL Cement Block Machine and have done everything that experienced workmen, skill and modern machinery can do to build a perfect machine. We have in the X-L-ALL Cement Block Machine the most perfect type of hollow concrete block machine possible to build. Note the simplicity of the machine; also its great strength. You will observe there are no cogs, gears or ratchets to become clogged up with cement, concrete, etc.; there are no springs on the machine to wear out or get out of order and the entire mould or flask is machined on automatic machinery. The boring and drilling is done by jigs, thereby insuring a perfect piece of workmanship. Note the manner in which the end doors are attached and removed. Not a single bolt, nut or screw to remove. When the operator of the machine finds it necessary to change an end door or face plate, he does not have to hunt around for a monkey wrench or a set of tools. Simply lift out the end door, insert the one wanted and go on with the work. The flask, or mould, is easily tilted over on its side after the cores are withdrawn and when this is done, the entire weight of the block rests on two end frames projecting from the base or stand of the machine, thereby making it rigid and does away with any possible chance of breaking the block while tilting or opening the machine. This feature is well worthy of your consideration.

With our X-L-ALL Cement Block Machine we furnish face plates and end plates to make whole blocks, half and quarter blocks, joist blocks, inside corner blocks, outside corner blocks, chimney blocks, pillar or column blocks in two styles. With our regular outfit you can erect a fine building, and the outfit will produce blocks which are used in the construction of seven-tenths of the work done with concrete building blocks.

Another feature of the X-L-ALL Cement Block Machine is the fact that it is only necessary to buy and use one style of pallet for either solid blocks, hollow blocks, half blocks or quarter blocks. Where either or both cores are not used, we furnish with the machine an attachment to set inside the front plate, thus blocking the core holes in the regular two-hole pallets. This will enable you to make either a solid block or fractional block without the expense of blind or solid pallets. This core attachment for the pallet is furnished with the machine. We also furnish a cast iron core gate for filling up the core space in the rear wall of the machine, thus enabling you to make a solid block or fractional block as if you had a solid flask or mould. The cores of the X-L-ALL Cement Block Machine are easily removed. Each core is fastened to the steel shaft by means of a set screw, making it easy to remove. The cores are withdrawn by the aid of two levers working on each side of the machine, thereby preventing any side draft or friction, making it absolutely impossible for the cores to pull sideways, causing blocks to crack while cores are being withdrawn from the new block.



The above illustration shows a concrete block, size 8x8x16 inches, made on the Standard X-L-ALL Cement Block Machine. This illustration shows the proportionate walls and size of core used in the 8x8x16-inch block. This block shows plain face, right hand plain end door and left hand core end door. Weight of this block is about 48 pounds

The X-L-ALL Cement Block Machine is shipped to you mounted on skids. The size of skid or sill placed under the machine should vary according to height of the operator.

On another page of this catalogue we show a hopper or feed table which will save its cost to any cement block maker the first week it is in use. If you do not buy one of these feed tables with your machine, you should at least make one out of wood, built along the same lines, for it is probably the greatest labor saving device used in connection with a cement block machine.

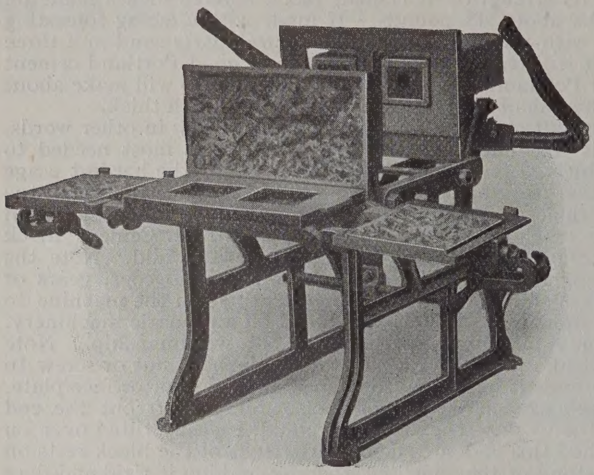
We guarantee every machine sold by us will please. If it does not, send it back after thirty days' trial and we will refund the price you paid and stand cost of transportation both ways.

MAKES 100 BLOCKS IN TEN HOURS.

Ladoga, Indiana.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your letter asking about cement block machine which I purchased of you, will say I have good success in making blocks with the X-L-ALL Machine. Two men can make 100 blocks in ten hours and do all the work. I would advise anyone purchasing a machine to buy not less than 100 pallets as the blocks have to stand from eight to twelve hours before removing from pallets. I use one part of Lehigh Portland cement to five parts medium gravel for common blocks for underground work. Also use the same mixture for finished blocks, except place about one inch and a half of sand to one-half inch cement in face to make a smooth surface. It also turns water and resists freezing. The only secret in making blocks so they will not stick is to use your mixture as dry as possible and keep the machine dry and clean with an old cloth or broom. The rock face of this machine is as fine an imitation of cut stone as any I have ever seen. G. A. MILLER.



The above illustration shows the Standard X-L-ALL Cement Block Machine with cores withdrawn and with mould or flask opened up, and a cast iron pallet placed in the machine ready to make block. Note how easy of access. The block is turned over on its side and rests on the pallet in front of the machine with the end doors dropped entirely out of the way, making it very easy to remove the block

Most manufacturers of cement block machines have a variety of attachments for making different shapes of blocks, which they sell at very high prices, but after anyone has had a little experience with one of our machines one soon learns that he can readily make many of these attachments at a very small expense. To illustrate, some machine manufacturers have special faces to make blocks for inside corners with half of the block rock face and half plain, quarter rock face and three-quarters plain, three-quarters rock face and one-quarter plain. The usual price asked for these three faces is about $3.00 each, or $9.00 for the set.

Now, with your X-L-ALL outfit you can lay the steel plate furnished with the machine over part of the rock face plate used for making half and quarter blocks; you will be able to produce a cement block 16 inches long, with one-half or 8 inches of the face showing rock design, while the other half of the block shows plain face. This would be an inside corner block. If you want an inside corner block with 12-inch facing and 4 inches of plain material, make a small sheet of steel to cover up one of the quarters of the rock face plate; you will then make a cement block with three-quarters of the facing rock design, and the other quarter plain. You can use any face plate for making half and quarter blocks with the same result; you will make an inside corner block just as good and save the cost of these three extra plates, which, from other manufacturers, would cost you $9.00. Should you use a very light piece of sheet iron, it might be well for you to fill the hollow spaces in the rock face with sand to support the sheet steel and prevent it from sagging down when the block is tamped. A good heavy gauge of steel, say 12 or 14-gauge, would not need any support. Almost any special plain style block needed can be made by using some arrangement just as simple and cheap as the device described above for making inside corner blocks, and purchasers of our machines may feel perfectly free to write us asking for advice on anything connected with the cement block business. Your letter will be answered by a man who is an expert in this line.

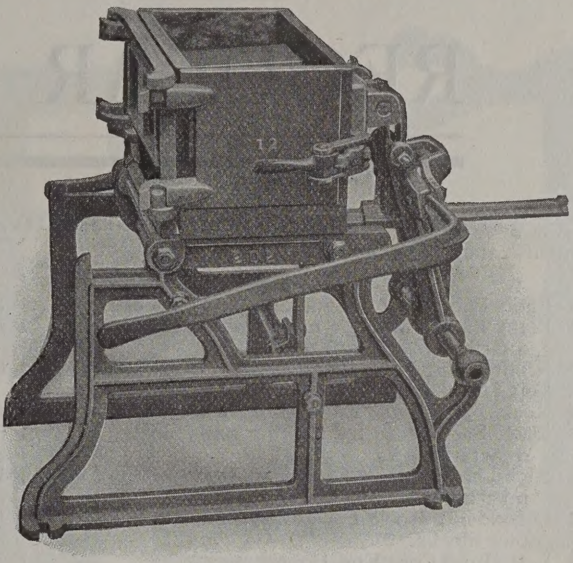
Our machines show careful attention to all details. Many block machines make blocks the same height on the back that they are on the face. If sufficient mortar is used, this makes an ugly looking mortar joint. Our machines make blocks that are slightly lower at the back than on the face. This enables the builder to use plenty of mortar and at the same time reduces the size of the mortar joint. This is one instance showing the careful investigation we have made and how we have applied our knowledge in the production of a perfect cement block machine.

There are many different sizes of blocks used, but more than 75 per cent of the manufacturers are now changing their machines to make blocks 16 inches long. The reason for this is that the 16-inch blocks are more convenient for the builder. One man can easily handle a 16-inch block, both in carrying it away from the machine and in laying it up in the wall. Blocks larger than 16 inches require two men to handle them, thereby doubling the cost of handling, besides the larger block is more liable to break. Another feature greatly in favor of the 16-inch block is the fact that studding in walls is usually spaced 16 inches from center to center. Floor joists are spaced 16 inches from center to center and builders find that blocks of this length are most convenient for them to use. The joist block attachment that we furnish enables you to form a block with an opening on each end and the two when placed together form an opening of the right size for 2-inch joists, either 6, 8, 10 or 12 inches wide. We place the joist where it will rest in the center of a block and supported by a block on either side. Numerous two-story factory buildings have been built, foundations and all, from 8-inch hollow cement building blocks, or occasionally the foundation wall is formed of grout with hollow cement building blocks used from the grade line up; various competent authorities state that hollow cement blocks 8 inches thick are sufficiently strong for any ordinary two-story building.

Another great advantage in the 8x8x16-inch size of X-L-ALL Cement Block Machine is that it can be operated by one man alone, if desired, and with very satisfactory results, although three men are required to work the machine up to its greatest capacity.

Note among these pages the testimonials from some of our customers who are using the X-L-ALL Cement Block Machine and see what they say their experience has been.

Every one of these letters is an actual statement from a user of cement block machines sold by us and we have printed a number of these letters to show the prospective buyers the possibilities of an X-L-ALL Cement Block Machine.



The above illustration shows the X-L-ALL Cement Block Machine in a position to best show the lock on the right hand end door and the position of the core levers and the core guides when the machine is closed up and the cores placed in position ready to finish a block. This also shows the very easy method by which the cores are withdrawn after the block is complete. Note the powerful leverage obtained and remember that two levers are used, one on each side of the machine, thus giving you great power without a possible jar or side strain on the machine that would have a tendency to crack the block

We have arranged different outfits or combinations of extras used with the Standard X-L-ALL Cement Block Machine, size 8x8x16 inches, to meet the requirements of practically every user of cement block machines. The Standard X-L-ALL Cement Block Machine is so arranged that either cast iron pallets, steel pallets or wood pallets may be used. We recommend the use of the steel pallet for several reasons. The steel pallet weighs but 4 pounds, it is much lighter and easier to handle around the machine. It is absolutely non-breakable and there is no danger of breakage or damage in transit, besides one hundred of these pallets weigh but 400 pounds, crated and packed for shipment, as against 700 pounds, the weight of one hundred cast iron pallets of the same size. The customer or prospective purchaser living at any considerable distance from Chicago will appreciate the saving made in transportation charges alone. If you live in the far west and the rate of freight is $2.50 per hundred pounds to your station on this class of machinery, you will have saved $10.00 in freight alone. The steel pallets are made from No. 14-gauge hot rolled open hearth Bessemer sheet steel, stamped and formed by dies under enormous pressure. This pallet will not warp or spring in handling the blocks. Cement blocks made on steel pallets should be placed on a floor or level ground, or the best way is to place your blocks on skids or strips of wood of sufficient size and weight to make a solid and level foundation for the blocks to rest upon. We recommend the steel pallet with our X-L-ALL 8x8x16-inch Cement Block Machine and guarantee them to make a block that is absolutely true and perfect. The next best pallet we believe to be the cast iron pallet, weight of which is a little more than 7 pounds each. Every cast iron pallet is inspected before packing for shipment so that we can insure every one being perfectly true. A few of our customers prefer the cast iron pallet because the blocks can be dried out in the yard on any kind of rough ground, and as the cast iron pallet absolutely cannot spring or warp, the blocks must be true.

Our X-L-ALL Cement Block Machines are all made so that a wood pallet may be used if desired. We do not recommend the use of a wood pallet and would very much prefer that our customers use a steel or cast iron pallet, because we know the results will be far more satisfactory. Cement blocks made on wood pallets are more or less liable to be a little warped or out of true. Wood pallets warp easily. It is hard to get any kind of lumber that will not swell or warp when subjected to wet and dry conditions alternately. The 8x8x16-inch Standard X-L-ALL Cement Block Machine is constructed to allow you to use a pallet ⅞ of an inch thick, with two cross cleats nailed across the under side at the ends. These cleats are to reinforce or strengthen the pallet to prevent warping so far as possible. It is advisable to saw narrow grooves in the under side of wood pallet and thoroughly saturate the pallet with hot linseed oil before using the first time. We have had the X-L-ALL Cement Block Machines made to accommodate the wood pallet to meet the demands of a few of our customers who wish to make their own pallets, thereby saving the price of steel or iron pallets as well as the freight charges on the same. If you will use care in selecting good material for making your wood pallets and if you will examine them from time to time and be sure that the pallets in use are true and not warped, there is no reason why you cannot make good blocks that are absolutely true on wood pallets. You must not attempt to use wood pallets that have warped or that are sprung out of shape. Throw them away. Do not use them.

AFTER LARGE EXPERIENCE DECLARED X-L-ALL MACHINE THE BEST.

Rosebud, Mont., Dec. 5, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—After my large experience with cement block machines I find that the X-L-ALL machine I purchased from you is the best I have ever seen. It works first class; I make seventy-five blocks a day alone. A friend of mine has a $200.00 machine and he only makes eighty blocks with three men, and I have sold twice as many as he has. He has two men to put them in the wall. It pays to make blocks 16 inches long, they are just right for one man to handle—saves labor.

I use one part cement to four parts gravel or sharp sand. What I like about your machine is, one man can make the blocks and put them in the wall, and with other machines I have seen it requires two or three men to make blocks and to put them in the wall. Respectfully, JOHN LUCAS.

REGULAR OUTFIT

With our regular outfit of Standard X-L-ALL Cement Block Machines, size 8x8x16 inches, we furnish the following outfit:

1 Plain Face Plate for making whole blocks.
1 Plain Face Plate for making half blocks and quarter blocks.
1 Right Hand Plain End Door.
1 Left Hand Plain End Door.
1 Rock Face Plate for making whole blocks.
1 Rock Face Plate for making half blocks and quarter blocks.
1 Right Hand Rock Face End Door for making return corner blocks.
1 Left Hand Rock Face End Door for making pier blocks.
1 Left Hand Core End Door.
1 Right Hand Core End Door.
2 Rear Core Gates.
2 Core Gates for pallets.
1 Dividing Plate to make core ends on half blocks.
1 Dividing Plate to make core ends on quarter blocks.
1 Graduated Bar for making halves and quarters and angle blocks.
1 Dividing Plate for making gable blocks.
1 Steel Striker.
1 Steel Carrier.
1 Double End Tamper.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Steel Plate for forming inside corner blocks.
1 Hook for withdrawing dividing plates.
1 Pressed Steel Pallet.
1 Cast Iron Pallet.
1 Wood Pallet.

A complete outfit depends mainly upon the quantity of blocks that are to be made daily, the different styles of faces and attachments such as bay window attachments, etc. Additional parts can be purchased at any future time and one can add to his outfit as business demands and experience shows just what parts are needed. We do not put the usual exorbitant price on parts or repairs, but sell them on the same basis as other goods. By referring to the list of parts which we furnish with the machine, known as our regular outfit, you will readily see the range of work which you can accomplish with this machine, and additional face plates, ends, pallets and other accessories can be obtained when wanted. We furnish three pallets with the regular outfit of our X-L-ALL Machine, only a sample of each, steel, cast iron and wood. We recommend the steel and cast iron pallets.

Remember, you must have as many pallets as you wish to make blocks during the day, as the green blocks must remain on the pallets for twenty-four hours. You should order pallets to suit the quantity of blocks you intend to make per day. The number of pallets depends upon how extensively you will go into the cement block business. Many of our customers have written that one man can easily make seventy-five blocks per day and do his own mixing, carrying away and curing. Two good men will make anywhere from 200 to 250 blocks per day, and if you will refer to some of the letters in this catalogue from our customers who are using the X-L-ALL Cement Block Machine, you will find that this capacity ranges anywhere from seventy-five to 125 blocks per man. Occasionally a customer reports better success.

Parts of Standard X-L-ALL Cement Block Machine, Size 8x8x16 Inches

(See illustration on opposite page.)

A Left Hand Base or Stand.
B Right Hand Base or Stand.
C Front Frame or Wall.
D Rear Frame or Back Wall.
E Pallet, size 8x16 inches.
F Face Plate, size 8x16 inches.
G Cast Iron Cores.
H Cast Iron Dividing Plates.
I Right Hand End Door.
J Left Hand End Door.
K Core Gates for rear wall.
L Core Gates for pallet.
M Joist Block Attachment.
N Horizontal Core Arm.
O Sliding Bar and Brace.
P Iron Core Levers.
Q Rear Brace for core levers.
S Flask Lock Levers.
T Upright Rocker Arm, right hand.
U Upright Rocker Arm, left hand.
V Cast Iron Clip for rocker shaft.
W Graduated Cross Bar for mould box.
X Steel Shaft for cores.
Y Steel Shaft for rocker arm.
Z Cross Braces for stand.

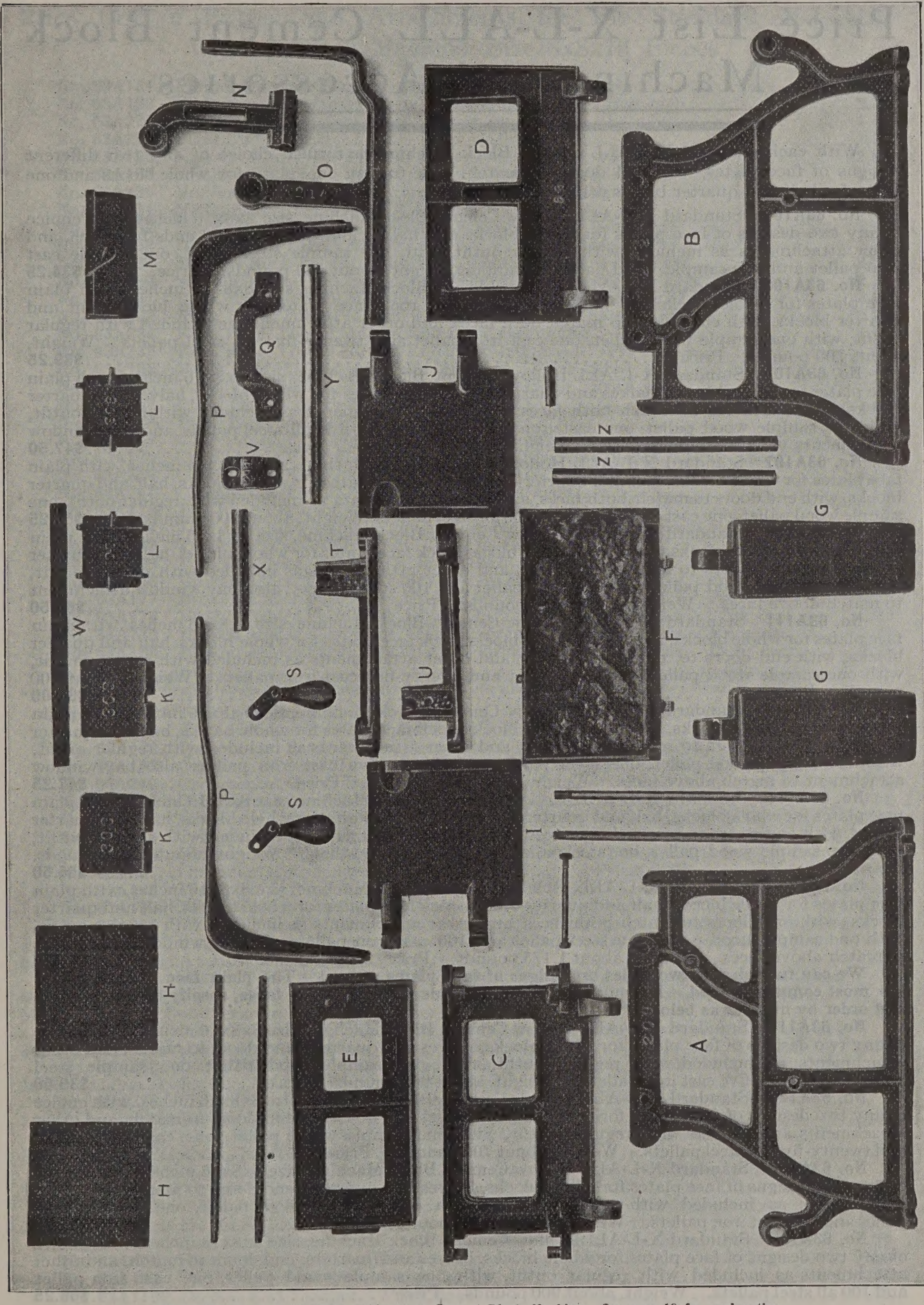


Illustration of parts of Standard X-L-ALL Cement Block Machine. See page 18 for explanation

Price List X-L-ALL Cement Block Machine and Accessories

With each standard X-L-ALL Cement Block Machine we furnish choice of any two different designs of face plates, with end doors to match. We furnish one plate for whole blocks and one plate for half and quarter blocks of two different designs.

No. 63A101 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks and halves and quarters, and ends to match, and other attachments as included with regular outfit, with one sample steel pallet, one sample cast iron pallet and one sample wood pallet. Shipping weight, about 500 pounds. Price........**$34.25**

No. 63A103 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks and halves and quarters, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 700 pounds. Price........**$39.25**

No. 63A105 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, halves and quarters, rock face plates for whole blocks, halves and quarter blocks with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one cast iron pallet and twenty-five all steel pallets and bay window attachments to match above faces. Weight, about 775 pounds. Price........**$47.50**

No. 63A107 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 900 pounds. Price,**$56.25**

No. 63A109 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one cast iron pallet and 100 steel pallets; also bay window attachment to match above faces. Weight, about 975 pounds. Price........**$64.50**

No. 63A111 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one steel pallet and twenty-five cast iron pallets. Weight, about 900 pounds. Price........**$39.00**

No. 63A113 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one steel pallet and twenty-five cast iron pallets; also bay window attachment to match above faces. Weight, about 875 pounds. Price........**$47.25**

No. 63A115 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one steel pallet and 100 cast iron pallets. Weight, about 1,100 pounds. Price........**$55.50**

No. 63A117 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces, and other attachments as included with regular outfit, with one sample wood pallet, one steel pallet and 100 cast iron pallets; also bay window attachment to match above faces. Weight, about 1,175 pounds. Price........**$63.75**

We can furnish any two styles or designs of face plates wanted. The plain face and rock face are most commonly used. If you want an outfit made up with other faces, specify designs wanted and order by number as below.

No. 63A119 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match, and other attachments as included with regular outfit, with one sample wood pallet, one sample steel pallet and twenty-five cast iron pallets. Weight, about 900 pounds. Price........**$39.00**

No. 63A121 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match, and other attachments as included with regular outfit, with one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 700 pounds. Price........**$39.25**

No. 63A123 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match, and other attachments as included with regular outfit, with one sample wood pallet, one sample steel pallet and 100 cast iron pallets. Weight, about 1,100 pounds. Price........**$55.50**

No. 63A125 Standard X-L-ALL Hollow Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match, and other attachments as included with regular outfit, with one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 900 pounds. Price........**$56.25**

Price List of Extras and Attachments for the Standard X-L-ALL Cement Block Machine, Size 8x8x16 Inches

No. 63A151	Plain Face Plate to make whole blocks. Price, each	$2.25
No. 63A152	Plain Face Plate to make halves and quarters. Price, each	2.25
No. 63A226	Plain End Door, right hand. Price, each	1.50
No. 63A227	Plain End Door, left hand. Price, each	1.50
No. 63A155	Medium Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A156	Medium Rock Face Plate to make halves and quarters. Price, each	2.25
No. 63A230	Medium Rock End Door, right hand. Price, each	1.50
No. 63A231	Medium Rock End Door, left hand. Price, each	1.50
No. 63A157	Heavy Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A158	Heavy Rock Face Plate to make halves and quarters. Price, each	2.25
No. 63A159	Shallow Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A160	Shallow Rock Face Plate to make halves and quarters. Price, each	2.25
No. 63A161	Rock Face, Tooled Margin Face Plate to make whole blocks. Price, each	2.25
No. 63A162	Rock Face, Tooled Margin Face Plate to make halves and quarters. Each	2.25
No. 63A234	Rock Face, Tooled Margin End Door, right hand. Price, each	1.50
No. 63A235	Rock Face, Tooled Margin End Door, left hand. Price, each	1.50
No. 63A165	Panel Face Plate to make whole blocks. Price, each	2.25
No. 63A166	Panel Face Plate to make halves and quarters. Price, each	2.25
No. 63A237	Panel End Door, right hand. Price, each	1.50
No. 63A238	Panel End Door, left hand. Price, each	1.50
No. 63A169	Cobblestone Face Plate to make whole blocks. Price, each	2.25
No. 63A170	Cobblestone Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A240	Cobblestone End Door, right hand. Price, each	1.50
No. 63A241	Cobblestone End Door, left hand. Price, each	1.50
No. 63A173	Tool Face Plate for making whole blocks. Price, each	2.25
No. 63A174	Tool Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A242	Tool End Door, right hand. Price, each	1.50
No. 63A243	Tool End Door, left hand. Price, each	1.50
No. 63A176	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each	2.25
No. 63A177	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each	2.25
No. 63A178	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each	2.25
No. 63A179	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each	2.25
No. 63A180	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each	2.25

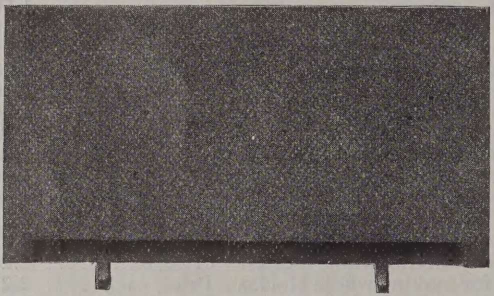
NOTE—To make half and quarter blocks for broken ashler work use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a whole block, produce very desirable results.

No. 63A232	Broken Ashler End Door, right hand. Price, each	1.50
No. 63A233	Broken Ashler End Door, left hand. Price, each	1.50
No. 63A182	Ornamental Scroll Design Face Plate for making whole blocks. Price, each	2.25
No. 63A183	Ornamental Scroll Design Face Plate for making halves and quarters. Each	2.25
No. 63A244	Ornamental Scroll Design End Door, right hand. Price, each	1.50
No. 63A245	Ornamental Scroll Design End Door, left hand. Price, each	1.50
No. 63A185	Ornamental Rope Design Face Plate for making whole blocks. Price, each	2.25
No. 63A186	Ornamental Rope Design Face Plate for making halves and quarters. Each,	2.25
No. 63A246	Ornamental Rope Design End Door, right hand. Price, each	1.50
No. 63A247	Ornamental Rope Design End Door, left hand. Price, each	1.50
No. 63A195	Water Table Face Plate for making whole blocks. Price, each	2.25
No. 63A196	Water Table Face Plate for making halves and quarters. Price, each	2.25
No. 63A248	Water Table End Door Attachment, to be fitted to plain end door for making right hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for right hand return corner wall. Price, each	.75
No. 63A249	Water Table End Door Attachment, to be fitted to core end door for making left hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for the left hand return corner wall. Price, each	.75
No. 63A251	Circle Face Plate, plain design, with two end door attachments for making 8-foot radius blocks, size 8x8x16 inches. Price, per set, complete	3.75
No. 63A252	Circle Face Plate, plain design, with two end door attachments for making 10-foot radius blocks, size 8x10x16 inches. Price, per set, complete	3.75
No. 63A253	Circle Face Plate, plain design, with two end door attachments for making 12-foot radius blocks, size 8x12x16 inches. Price, per set, complete	3.75
No. 63A255	Circle Face Plate, rock design, with two end door attachments for making 8-foot radius blocks, size 8x8x16 inches. Price, per set, complete	3.75
No. 63A256	Circle Face Plate, rock design, with two end door attachments for making 10-foot radius blocks, size 8x10x16 inches. Price, per set, complete	3.75
No. 63A257	Circle Face Plate, rock design, with two end door attachments for making 12-foot radius blocks, size 8x12x16 inches. Price, per set, complete	3.75
No. 63A100	Cast Iron Pallets for 8x8x16-inch blocks. Weight, 7 pounds. Price, each	.25
No. 63A200	Steel Pallets for 8x8x16-inch blocks. Price, each	.26
No. 63A150	Steel Carrier for 8x8x16-inch blocks. Price, each	.75
No. 63A1100	Double End Tamper. Price, each	.75

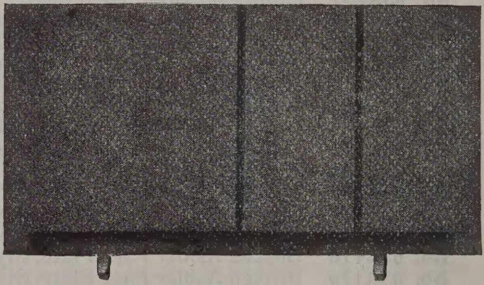
Designs of Regular Face Plates

For Making Whole Blocks (8x16 Inches) and Fractional Blocks on Both the Standard and Improved X-L-ALL Hollow Cement Block Machines

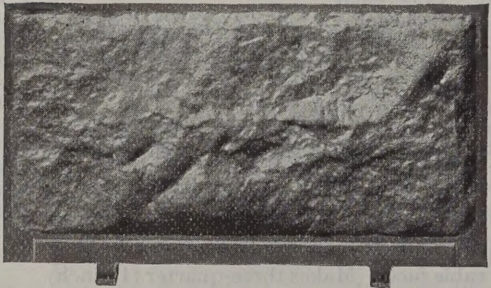
Every X-L-ALL face plate is made from cast iron patterns that have been machined and trued up to gauge. Every face plate is ground and machined on automatic machinery and is absolutely square and true. We use the greatest care in making face plates. Face plates, size 8x16 inches, weigh about 35 pounds each. These face plates are interchangeable with the Standard X-L-ALL and Improved X-L-ALL Machines and the same face plate is used in the 8x8x16-inch, 8x10x16-inch and 8x12x16-inch Improved X-L-ALL Cement Block Machines.



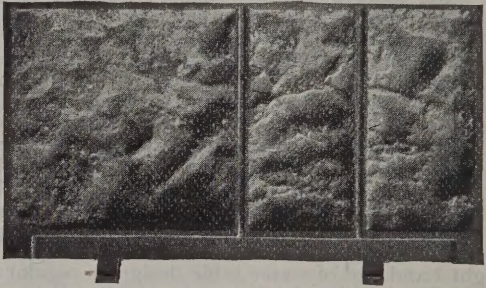
Plain Face Plate, size 8x16 inches, for making whole blocks on X-L-ALL Cement Block Machines. This face plate is used for making plain face blocks for foundations, inside walls, partitions, etc.



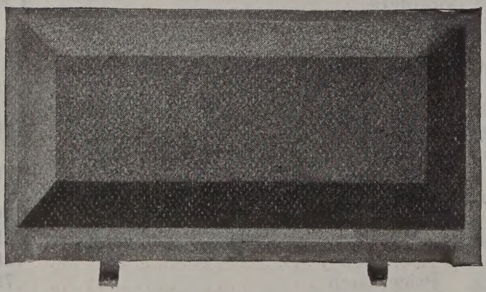
Plain Face Plate, size 8x16 inches, for making half and quarter blocks on all X-L-ALL Cement Block Machines.



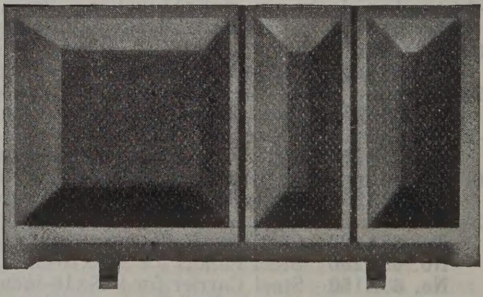
Medium Rock Face Plate, size 8x16 inches, for making whole blocks on X-L-ALL Cement Block Machines. This style of face plate is probably more universally used than any other design. When used in connection with two rock face end doors they make very desirable blocks for building porch piers, etc.



Medium Rock Face Plate, size 8x16 inches, for making half and quarter blocks on X-L-ALL Cement Block Machines

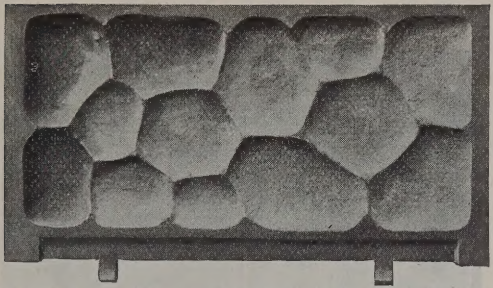


Panel Face Plate, size 8x16 inches, for making whole blocks on X-L-ALL Cement Block Machines

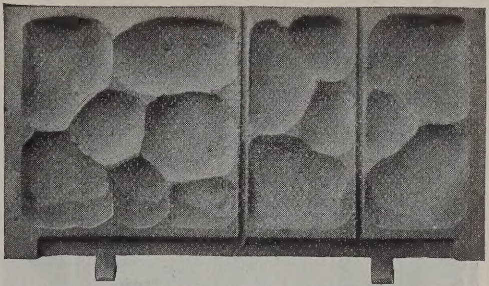


Panel Face Plate, size 8x16 inches, for making half and quarter blocks on X-L-ALL Cement Block Machines

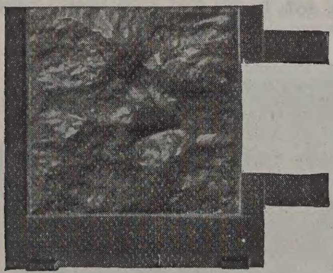
DESIGNS OF REGULAR FACE PLATES—Continued



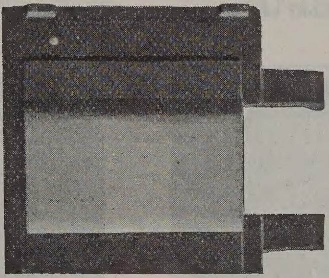
Cobblestone Face Plate, size 8x16 inches, for making whole blocks on X-L-ALL Cement Block Machines



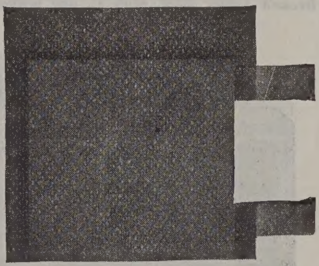
Cobblestone Face Plate, size 8x16 inches, for making half and quarter blocks on X-L-ALL Cement Block Machines



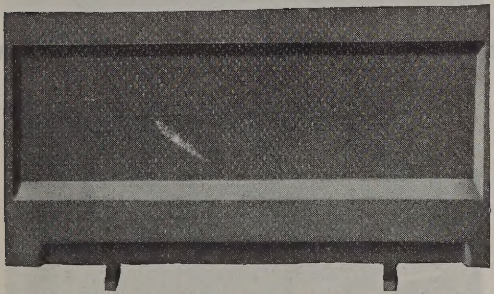
Right Hand End Door, Rock Face Design, X-L-ALL Machine



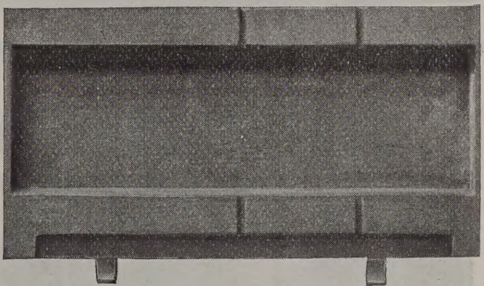
Left Hand End Door for making core ends on regular wall blocks



Plain End used for inside corners and return corners used with plain face



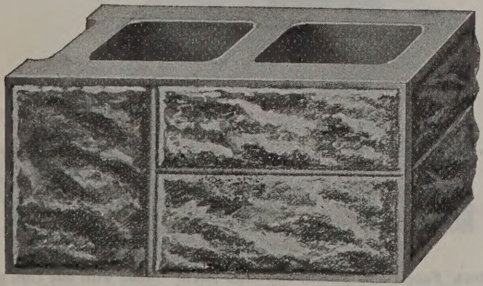
Water Table Face Plate, size 8x16 inches, for making whole blocks on X-L-ALL Cement Block Machines



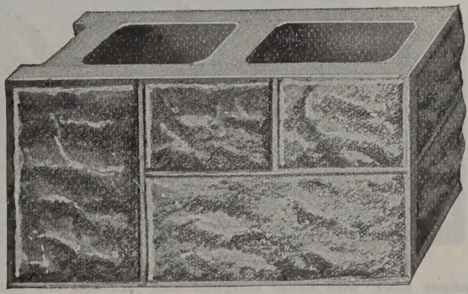
Water Table Face Plate, size 8x16 inches, for making half and quarter blocks on X-L-ALL Cement Block Machines

Hollow Concrete Blocks

Made on the Standard X-L-ALL and Improved X-L-ALL Cement Block Machines, Size 8x8x16 Inches

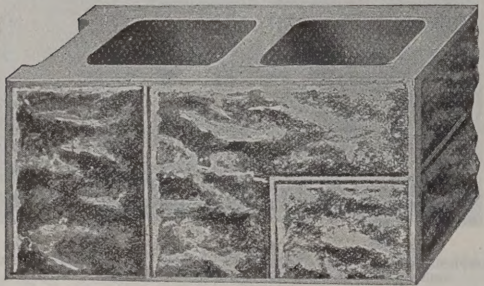


Broken Ashler Face, Style A, one broken ashler end, one regular core end

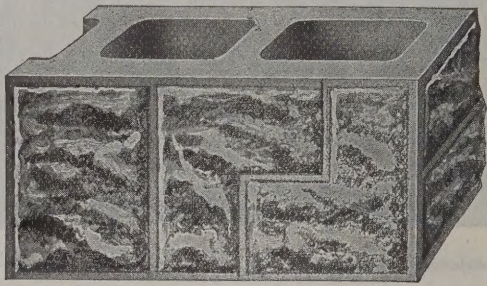


Broken Ashler Face, Style B, one broken ashler end, one regular core end

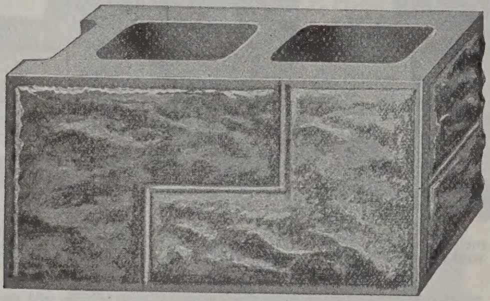
HOLLOW CONCRETE BLOCKS—Continued



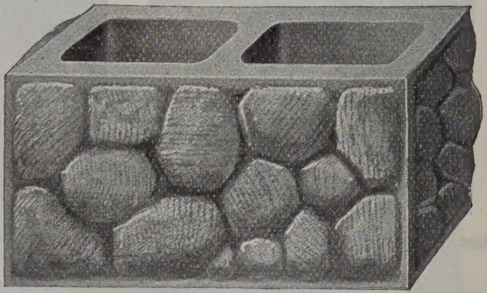
Broken Ashler Face, Style C, one broken ashler end, one regular core end



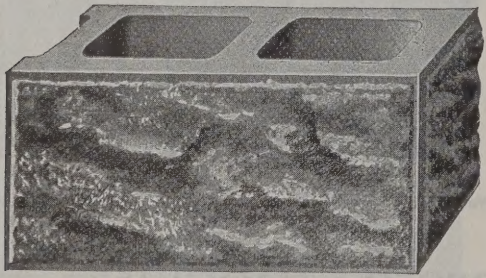
Broken Ashler Face, Style D, one broken ashler end, one regular core end



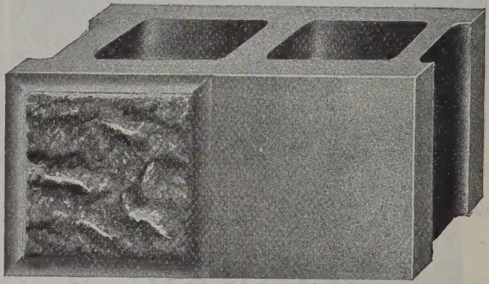
Broken Ashler Face, Style E, one broken ashler end, one regular core end



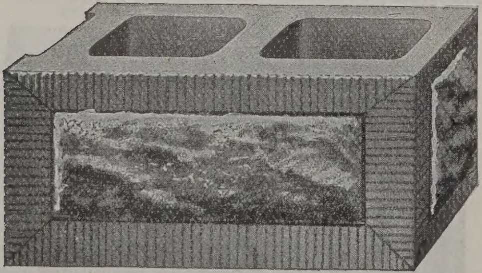
Porch or Pier Block, cobblestone face and two end doors to match



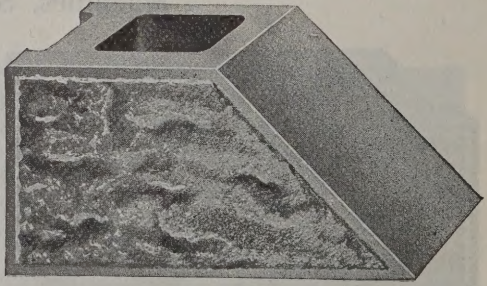
Medium Rock Face Block for return corners, one rock end, one regular core end



Inside Corner Block with half of face rock design and other half plain. Both ends made with regular core end door

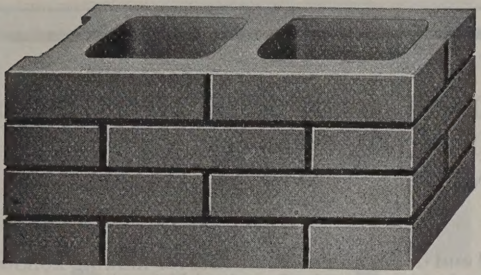


Medium Rock with tooled marginal edge face and one end to match face. This is known as a return corner block

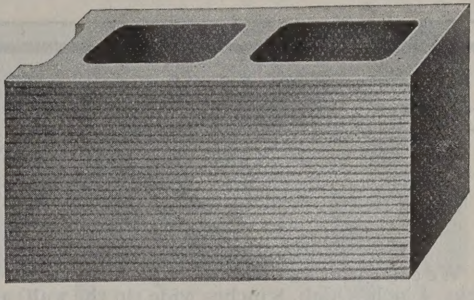


Rock Face Gable Block, one-third pitch. Made with one core end door, and gable angle plate furnished with every machine. Gable blocks can be made either one-quarter, one-half or one-third pitch

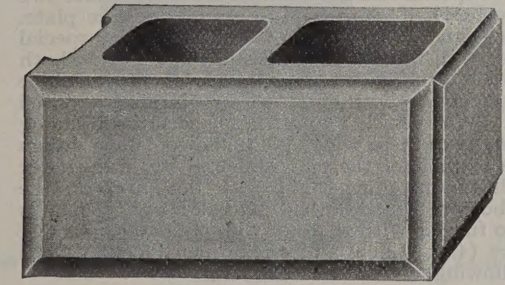
HOLLOW CONCRETE BLOCKS—Continued



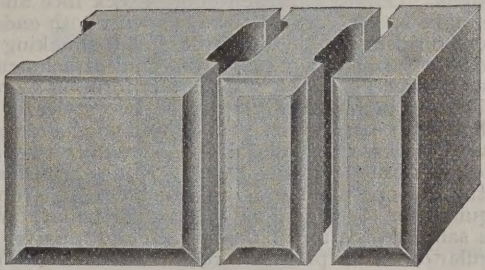
Imitation Pressed Brick Face and one end to match. Chimney blocks of the same design can be made by use of the chimney block attachment



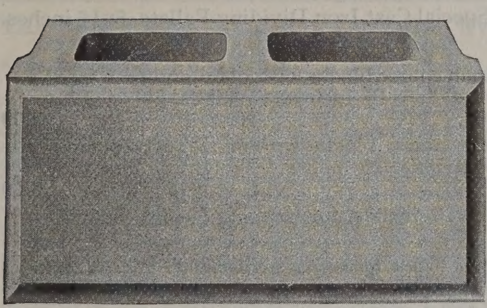
Corrugated Tool Face, one plain end, one regular core end



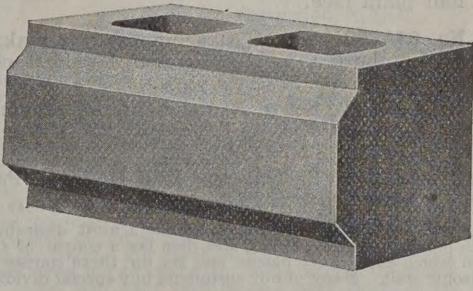
Panel Face Design, one panel end to match, one regular core end



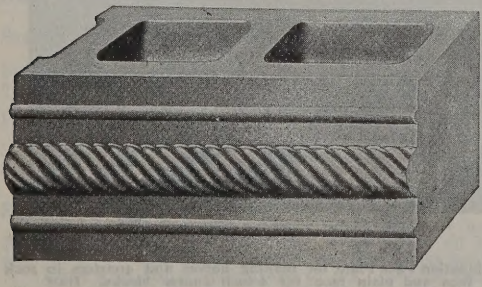
Fractional Blocks with panel face design. The half block shows two core ends. The inside quarter block has two core ends, the outside quarter block has one plain end and one core end. These blocks are made by our new design dividing plates



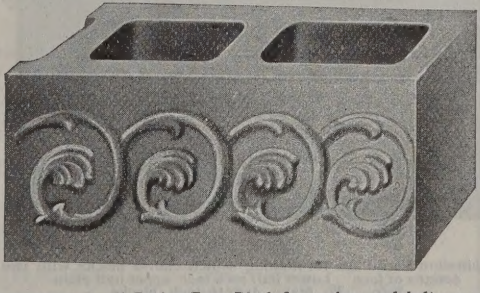
Joist Block with panel face. The openings in each end are made with our regular joist block attachment



Water Table Block. Made on the 8x8x16-inch X-L-ALL. We furnish right and left hand end door attachment for making the same design on the end for return corner blocks



Ornamental Face Block for copings and belt courses. Shows one plain end and one core end. Rope face design



Ornamental Scroll Design Face Block for copings and belt courses Shows one plain end and one core end

X-L-ALL ATTACHMENTS

FOR MAKING 4-INCH COURSE BLOCKS ON THE STANDARD X-L-ALL HOLLOW CEMENT BLOCK MACHINE

We can furnish a double face plate and set of special end doors and attachments for making hollow blocks, 4 inches high, 8 inches wide (in the wall) and 16 inches long, on the Standard X-L-ALL 8x8x16-inch Cement Block Machine. This outfit consists of a double face plate, with a groove running through the center lengthwise, into which the special inside pallet rests. This face plate is made with two different designs. One plate has rock face on the lower half and a plain face on the upper half of the plate. With this double face plate we furnish two special end doors which are divided into two designs. One-half of each door is rock face and the other half plain face to match the face plate. To make return corners or blocks with both ends of the same design as the face, use the two special doors furnished with the outfit, but for making regular wall blocks which should be cored on both ends we furnish two cast iron end attachments which are placed in the ends of the machine over the special end doors, thereby forming a groove or core on both ends. There is also required a dividing pallet for dividing the two styles of faces. We furnish two of these special or dividing pallets with each outfit. If you find you have use for many of these 4-inch plain and tool face design course blocks, you would probably require twenty-five or more of these dividing pallets. The lower block is formed on the regular pallet furnished with the machine. The rock design is on the bottom of one plate and the panel design is on the bottom of the other plate. No extra pallets required for these designs; use regular pallet. We also furnish with the outfit a double face plate of the same design for making half and quarter blocks (4x8x8-inch and 4x4x8-inch blocks.) The regular outfit for plain and rock face consists of the following:

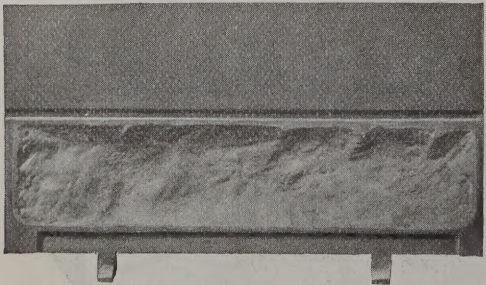
1 Double Face Plate for making two designs of 4-inch course blocks, 4x8x16 inches, with plain face and rock face combination.
1 Double Face Plate of the same design for making half and quarter blocks.
1 Special Right Hand End Door, half rock and half plain face.
1 Special Left Hand End Door, half rock and half plain face.
2 Cast Iron End Attachments for forming core end opening in blocks.
2 Special Cast Iron Dividing Pallets, 8x16 inches.

No. 63A290 Set of Attachments for making 4-inch course blocks with plain and rock face for the Standard X-L-ALL Cement Block Machine, size 8x8x16 inches. Weight, about 125 pounds. Price.......... **$9.00**

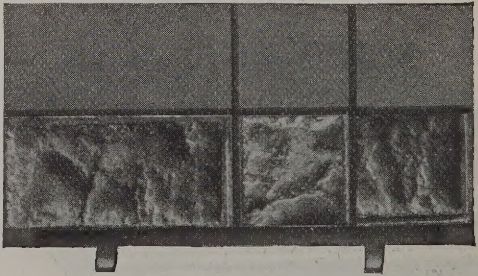
No. 63A292 Set of Attachments for making 4-inch course blocks with panel and tool face for the Standard X-L-ALL Cement Block Machine, size 8x8x16 inches. Weight, about 125 pounds. Price.......... **9.00**

No. 63A294 Special Cast Iron Dividing Pallets, 8x16 inches, for making 4-inch course blocks. Price, each.......... **.30**

NOTE—4-inch course blocks make a most desirable style of block to use on any building. Lay a course of 8-inch blocks, rock face design, and then lay a course of 4-inch blocks either plain face or tool face or reverse the style of the 4-inch and 8-inch blocks and lay up these courses alternating with 4-inch and 8-inch blocks and you have a handsome wall. Many of our customers buy special dividing pallets in lots of 100 at a time.

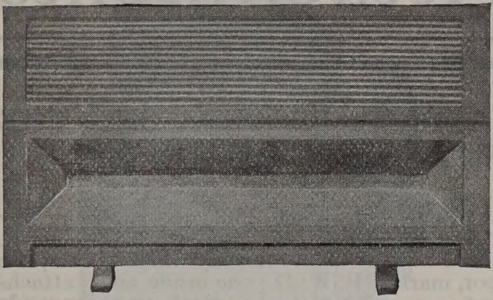


Combination Face Plate for making 4-inch course blocks with two designs of face Lower half rock face upper half plain face. To make 4x8x16-inch blocks

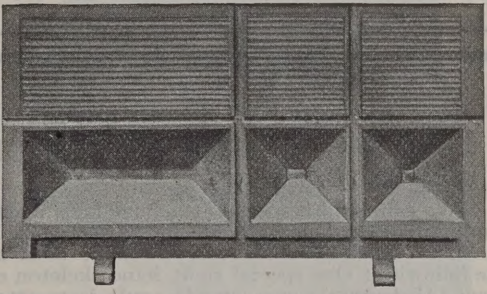


Combination Face Plate for making halves and quarters in rock face and plain face for 4-inch course blocks. Half blocks are 4x8x8 inches and quarter blocks are 4x4x8 inches

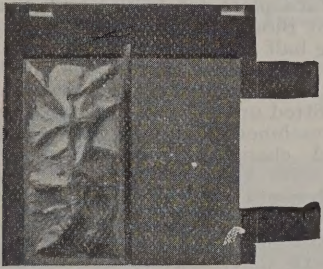
X-L-ALL ATTACHMENTS—Continued



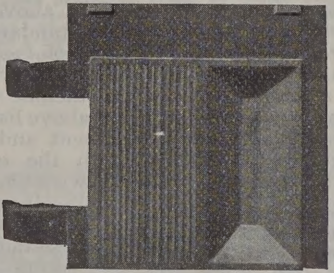
Combination Face Plate for making 4-inch course blocks with two designs of face. Lower half is panel face and upper half is tool face. To make 4x8x16-inch blocks



Combination Face Plate for making halves and quarters in panel face and tool face for 4-inch course blocks. Half blocks are 4x8x8 inches and quarter blocks are 4x4x8 inches



Left Hand End Door, half plain and half rock face, for 4-inch course blocks



Right Hand End Door, half panel and half tool face, for making 4-inch course blocks

NOTE—We furnish cast iron attachments to insert in the end of the machine over the special end door to form a core or open end for standard wall blocks. These attachments are furnished with every outfit, thereby making it unnecessary for you to buy more than one pair of doors with an outfit.

THE BEST ROCK FACE BLOCK HE HAS EVER SEEN.

Carrington, N. Dak.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:— Replying to your letter asking how I like the cement block machine purchased of you, will say that I find it perfectly satisfactory in every way. It makes a fine block and the rock face is the best I have ever seen. I don't know just how much I saved on the machine, but I know of one machine in Carrington which an agent offered to me for $300.00. It makes a block 24 inches long, 10 inches wide and with an air space in the middle tied together with two wires. I don't like it as well as I do my 16x8 machine which has an air space, and as one block lays on three I think it makes a stronger wall. I have only made about 500 blocks, making them for my own use for the foundation of a house 24x43 feet. People who have never used cement and buy a block machine should have a formula for mixing the cement. I did not receive a formula with my machine, but it did not make any difference to me for I have used cement for the last thirty years. The way I mix for outside is three of sand to one of Portland cement; the balance is mixed five to one—five sand and one cement. I have the two kinds mixed before I commence. My machine makes face down so I put in two brick trowels of the rich; that is, three to one mixture, in the bottom then one spade of the poorer before I commence to tamp it; then keep on with the poorer mixture until the mould is full. The sand should be screened for the face, and gravel can be used for the rest. Two men can make about 150 blocks in ten hours. For the lining I use it five of sand to one of cement; gravel does no harm. Then to cure them they must not be in the sun; keep them in the shade for a few days, give them a good sprinkling every morning. After they have been made a week they can be piled up outside and covered with hay or straw to keep the sun off, and it is a good plan to keep the straw damp. If they are made in that way they will be all right. Yours very truly, F. E. BURNHAM.

SUCCEEDS THOUGH A NEW MAN AT THE BUSINESS.

Paris, Ark., Jan. 9, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Some days ago you sent me a letter in regard to the X-L-ALL Cement Block Machine I purchased from you some time ago. I received the machine in good condition. I am a new man in that line of business but have found the machine to be all O. K. It makes a fine block.

I like the steel pallets better than the cast iron pallets because they are much better to handle and not so easy to break. I would like to have all the information on the X-L-ALL Cement Block Machine you can give me.

Yours respectfully, CHAS. G. FISCHER.

SO SUCCESSFUL WITH ONE MACHINE THAT HE WILL BUY ANOTHER.

Belton, S. Car., Dec. 20, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Kind Sirs:—In reply to your letter received some time ago, will say that I am well pleased with my X-L-ALL Cement Block Machine. I can make all the blocks I need with very little cost. I would not be without it. I think I will run two machines next spring and make blocks for the public.

I will send you a photograph of my house as soon as it is finished. Yours truly,
E. O. BROWN.

Bay Window Attachments

FOR 8x8x16-INCH 45-DEGREE ANGLE BLOCKS ON THE STANDARD X-L-ALL CEMENT BLOCK MACHINE

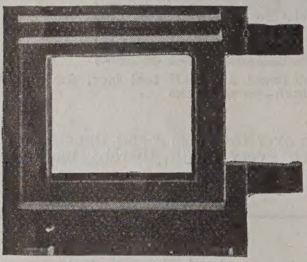
We can furnish special attachments to make both inside and outside 45-degree angles for bay window blocks, angle walls, etc., on the Standard X-L-ALL Cement Block Machine, size 8x8x16 inches.

The attachments necessary to make both inside and outside angles for bay windows comprise the following: One special right hand skeleton end door, marked B. W. D.; one inside angle attachment (45 degrees); one outside angle base attachment; one wing plate to attach to the outside angle base. (Be sure to specify style of bay window plates.)

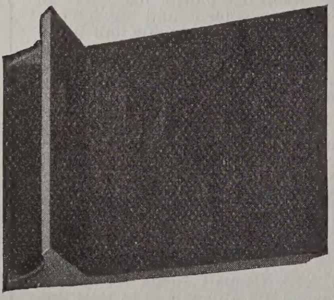
Use any style of regular face plate for making half and quarter blocks. It requires this face plate to use in connection with the above attachments. Face plate for halves and quarters not included with attachments. The Standard X-L-ALL Cement Block Machine, size 8x8x16 inches, is furnished regularly with two styles of face plates for making half and quarter blocks, namely, plain face and rock face, but any other two styles may be substituted at the wish of the purchaser. If you order a Standard X-L-ALL Machine with regular outfit, and specify bay window attachments for same, we would send you the above list of attachments fitted up with two designs of face plates, namely, one plain face attachment and one rock face attachment. If you were to change the regular equipment of faces with the machine, we would change your order for bay window attachments to match the outfit with your machine.

If you buy these attachments from us later on, remember that you must specify the style of faces wanted and that you must use these faces and attachments in connection with the face plates for making halves and quarters that you already have with your machine. Face plate is not furnished with the bay window attachment. Use the one with your machine or order it separately.

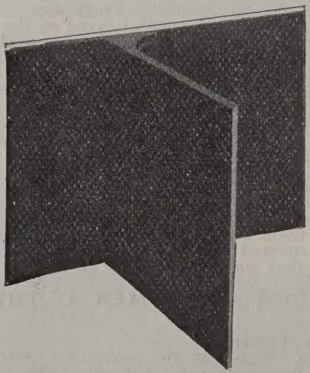
To use these attachments on the Standard X-L-ALL Cement Block Machine, first remove both cores from the machine, fill the core holes with the core plates provided for that purpose, use the regular two-hole pallet with plugs or core gates same as when making solid blocks. The inside angle blocks can be made with or without core. We are advised that many of our customers prefer to make them solid.



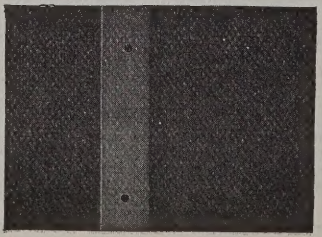
The above illustration shows a Skeleton End Door, which is placed on the right hand end of the machine when making bay window blocks. Use a core end door (regular door) on the left hand end of the machine. This, together with the angle plates, completes the equipment.



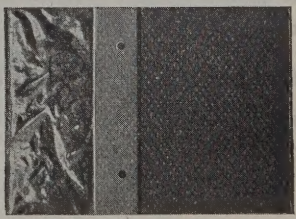
This illustration shows the Inside Angle Attachment (45 degrees) for making inside angle blocks. First place a face plate in the bottom of the machine for making half and quarter blocks, then insert the skeleton end door, then this inside angle casting, having the long end of the plain face rest in the middle groove of the face plate and fasten the top end under the grooved rim of the special end door. When the attachment is in the machine, the lettering "Inside 8" will be on top.



This illustration shows the Outside Angle Base Attachment, to which wing plates of different designs are bolted to match face plate. After fitting the angle plate with a special face design, put the angle inside the machine and have the end or section with the wing plate placed in the middle groove of the face plate in the machine, then tilt the angle casting to the right and fasten it under the grooved rim of the special end door. Lock up the machine and you are ready for work.

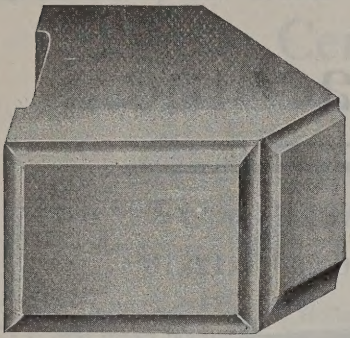


This illustration shows a Wing, the short or narrow end of which is made of a design to match the face plate. This illustration shows a Plain Face Wing to match the plain face of your machine for making halves and quarters. This wing is bolted to the outside angle base attachment.

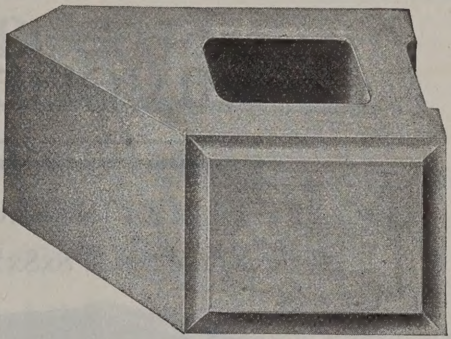


This illustration shows a Wing Plate, the short or narrow end of which is made of different design to match the face plate. This wing plate is bolted on to the outside angle base attachment for forming different designs of outside angle bay window blocks. This illustration shows a rock face wing plate. We can furnish these wings in either plain, rock, panel or corrugated design as wanted.

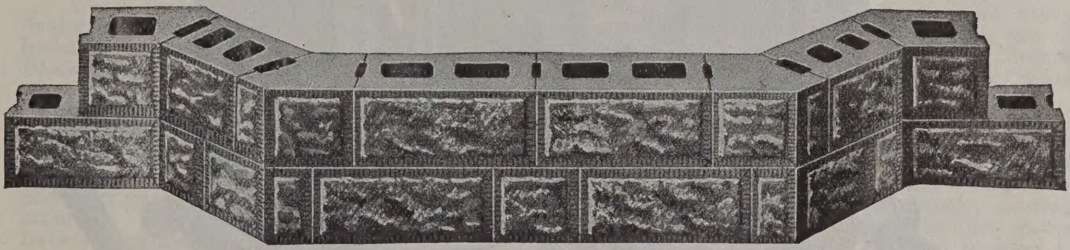
BAY WINDOW ATTACHMENTS—Continued



The above illustration shows an Outside Angle Block (45 degrees), panel face design, made on the regular face plate for halves and quarters and the panel face bay window attachment. The outside angle block is made without core.



The above illustration shows an Inside Angle Block (45 degrees) made on a regular bay window attachment with panel face design. These blocks are all made with the outside end formed with a core as on regular wall blocks. The outside angle block can be made either with or without core.



Bay windows are generally made at an angle of 45 degrees, but they can be made any angle desired. The illustration shows how to lay up bay window blocks so as to break joints and make the bay as large or as small as wanted. The projection of the bay window can be made large or small by using whole blocks or fractional blocks, as necessary to make the required depth or projection. The illustration above shows a projection of one full length block. In the lower tier of the front wall we show a whole block laid up to the angle block, then a half block and another whole block to reach the other angle. The top layer shows an inside angle block on the right hand corner, then a full length (16-inch) regular block to bring the bay out to meet the outside 45-degree angle block which will carry the wall along parallel with the walls of the building until the necessary length is obtained, when you will carry the wall back at an angle of 45 degrees by using inside and outside angles as before. You will observe from this illustration how easily and perfectly every joint is properly broken by having a solid block directly over the opening and with no seam or joint on the outside corners. The lower course represents the first third and fifth courses, while the upper course shows the second, fourth and alternate courses.

Price List of Bay Window Attachments for Standard X-L-ALL Cement Block Machine, Size 8x8x16 Inches

No. 63A280 Complete Set of Attachments for making inside and outside angles (45 degrees) fitted up for plain face and rock face. Attachment consists of five pieces. Bottom face plate not included. Price.. **$8.25**

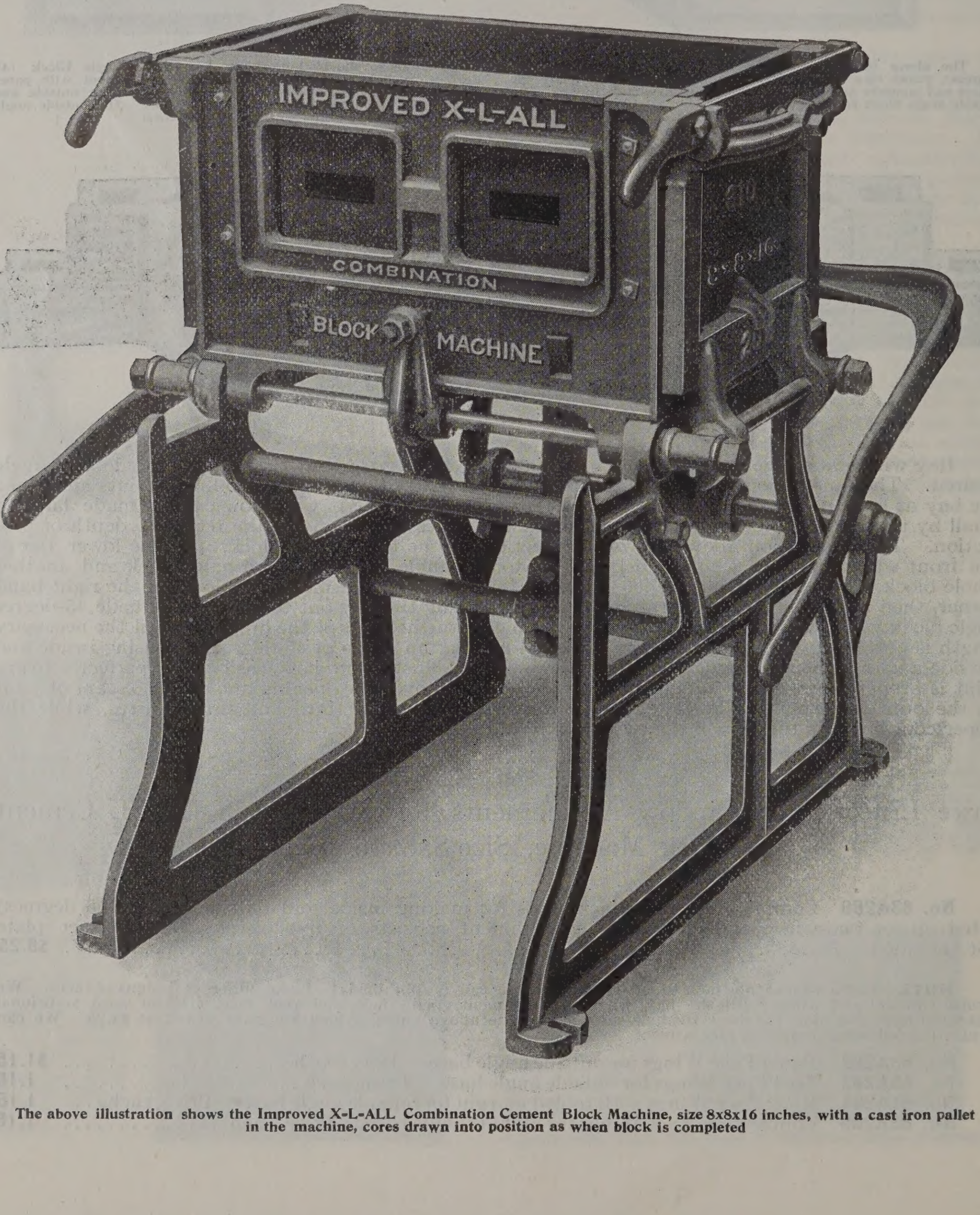
NOTE—Extra wings to attach to outside angle base can be obtained to make different designs of faces. We furnish two styles of wings with the bay window attachment, plain face and rock face. If you want additional designs of faces you must purchase them in addition to the above outfit, which we have priced at $8.25. We can furnish the following designs of face wings:

No. 63A282	Panel Face Wings for outside angle base. Price, each	**$1.15**
No. 63A283	Tool Face Wings for outside angle base. Price, each	**1.15**
No. 63A284	Rock Face Wings with tooled margin for outside angle base. Price, each. ..	**1.15**
No. 63A285	Cobblestone Face Wings for outside angle base. Price, each	**1.15**

The Contractor's and Builder's Favorite Machine

INTERCHANGEABLE

Three Sizes, 8x8x16, 8x10x16 and 8x12x16



The above illustration shows the Improved X-L-ALL Combination Cement Block Machine, size 8x8x16 inches, with a cast iron pallet in the machine, cores drawn into position as when block is completed

The Improved X-L-ALL Combination Hollow Cement Block Machine

The Improved X-L-ALL Hollow Cement Block Machines are all "Face Down" Machines, Which Experience Has Taught Us is the Only Practical Way of Making a Concrete Building Block

THE Improved X-L-ALL Hollow Cement Block Machine is the only machine made that will make hollow blocks "face down" in three different sizes for walls of different widths. The Improved X-L-ALL Cement Block Machine is made in three sizes, namely, 8x8x16 inches, 8x10x16 inches and 8x12x16 inches. You can purchase a separate and complete machine of each size, or you can buy one complete machine of either of the three sizes and afterwards purchase a set of complete attachments for making the other two sizes of blocks. These machines are so arranged that there are but very few small and inexpensive parts required to change the machine from one size to another.

Every contractor, every carpenter or builder and every manufacturer of artificial stone, every dealer in building material should have a stock of building blocks suitable for any kind or size of building that might be required in his locality. Buy an 8x8x16-inch Improved X-L-ALL Hollow Block Machine today and add the other attachments for making 10-inch and 12-inch blocks when wanted.

The Improved X-L-ALL Cement Block Machine is designed and built along thorough mechanical lines. Every casting is made from iron patterns which have been machined and dressed to gauge, thereby securing the very best work possible. All parts of the Improved X-L-ALL Cement Block Machines are interchangeable, the boring is all done on jigs, and all of the face plates, end doors and other parts of the flask or mould are ground and dressed on automatic grinders, thereby insuring accuracy. The flask or mould of the machine is squared up absolutely true and the face plates have a marginal edge on which the side of the pallet rests and the back wall is grooved to allow it to fit up over the edge of the face plate, thus preventing any concrete from working through or making a rough edge on the block. The Improved X-L-ALL Machine is locked up and made absolutely true by two bar levers which draw the front and rear walls of the machine absolutely tight and square at both top and bottom and is easily closed and locked for moulding, or opened up for removing the block. To open up the machine, take hold of the grips on each side of the machine, lift them up gently and with them push the back wall away from the new block and let the two handles remain in an upright position. Now let the tops of the two end doors fall outward, they being hinged at the bottom on the main frame of the machine, and draw the front wall of the machine with the new block toward you. This shifts the position of the block from the face plate to the pallet, as shown on page 32, where we illustrate the Improved X-L-ALL Cement Block Machine opened up and the new block carried away. All three sizes of the Improved X-L-ALL Cement Block Machine make face down blocks and all machines use the same face plates, but a different pallet is required for every size of cement block machines. All three sizes of Improved X-L-ALL Cement Block Machines are so built that either wood or iron pallets may be used.

See page 50 for view of skeleton frame or stand used for all three sizes of Improved X-L-ALL Combination Block Machines. We also show an illustration of every part included in the extra attachments for changing the machine from one size to another.

An 8x8x16-inch hollow concrete block made on the X-L-ALL Cement Block Machine weighs about 48 pounds.

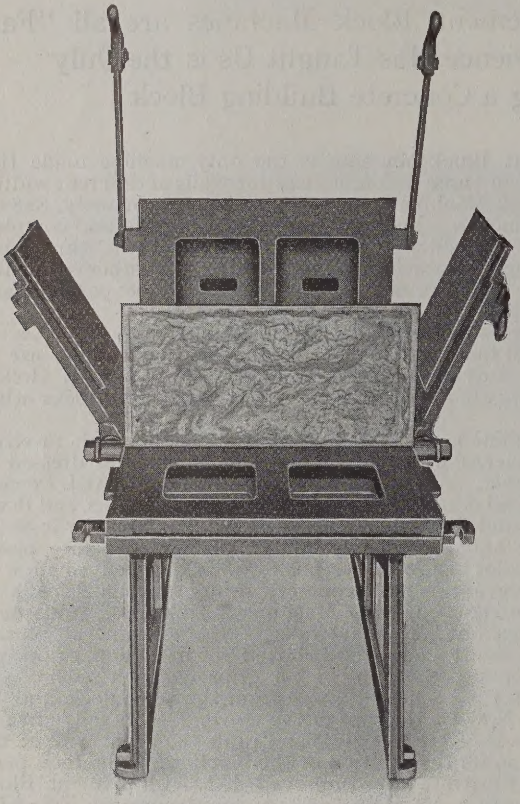
Every Improved X-L-ALL Combination Cement Block Machine is a face down machine and of the most modern type.

The Improved X-L-ALL Combination Cement Block Machine is fully guaranteed. We ship the outfit and give you thirty days' trial to decide whether or not the machine is what we claim it to be. Your money refunded if machine is not perfectly satisfactory.

There is practically but one style or type of cement block machine recognized among the leading manufacturers of concrete building blocks. At the recent convention of Concrete Machinery Manufacturers, held in Chicago, there appeared to be only a few side face machines. Practically every manufacturer of cement block machinery is beginning to manufacture face down machines. We gave this point a most thorough study a couple of years ago when we first commenced investigating this industry. At this time there were but a few machines built for making face down blocks. Those few manufacturers are still growing and are now the leading concrete block manufacturers of the country. Our claims for a face down machine are, that it enables you to make building blocks with a better facing material. Cement being the most costly ingredient used in the manufacture of cement blocks and at the same time the most necessary to insure a long life to concrete, it must be used in proper proportions to give it life, and it should be used at the proper time and place to obtain best results. A concrete block made on the X-L-ALL Cement

Block Machine is made on a face placed in the bottom of the mould, enabling you to use one part cement and one part fine sand for facing the block. Some use half and half, while others use one part cement to two parts sand. The more cement, the more dense will be the face of the block and the more impervious to moisture. This facing should be about one inch thick over the face plate. This will produce results that never could be obtained on a side face machine.

A hollow cement block, size 8x8x16 inches, weighs between 48 and 50 pounds each. At a basis of one part of sand and one part of cement for facing and the balance of the block one part cement, two of sand and three parts of gravel, 1½ barrels of good Portland cement, 1¼ yards of sand and gravel will make seventy-two hollow cement blocks. A concrete block, size 8x8x16 inches, is equal to fourteen bricks in the wall, including allowance for mortar. Without allowance for mortar joint, one block is equal to sixteen bricks.



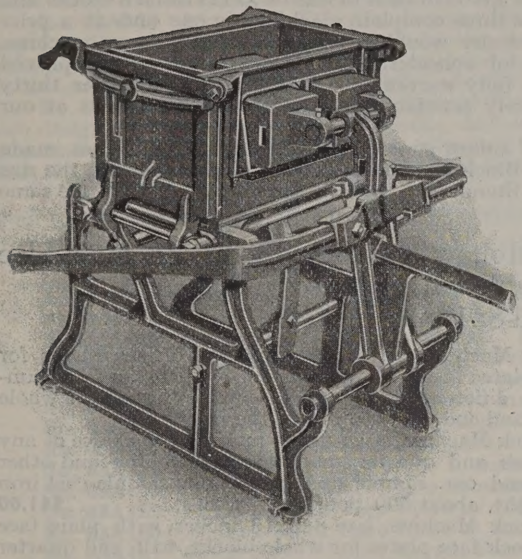
The above illustration shows the Improved X-L-ALL Combination Cement Block Machine with flask or mould opened, front wall or pallet tilted over toward you so that the new cement block rests on the pallet. This illustration shows the machine after the block has been carried away and a new pallet inserted ready to make another block

We have built the Improved X-L-ALL Cement Block Machine to make three different sizes of blocks of the sizes selected by concrete engineers, contractors, etc. We have the three different sizes of blocks universally used in all kinds of work in all parts of the country. With these three machines or with one single machine and the two complete sets of extra attachments for the two other sizes, you can make either hollow or solid concrete blocks, 8x8x16, 8x10x16 and 8x12x16 inches. These three sizes of blocks have been found to lay up in the wall much better than any other size. Another very important feature in favor of 16-inch building blocks is the fact that they can be made and carried away from the machine by one man and they can be carried up and laid in the wall by one man. This means a saving to you of the cost of one extra man as a helper.

Remember this when making up your order for an outfit. Figure what it will cost you to use 20-inch, 24-inch and 30-inch blocks made on other machines. The other man may tell you that he can lay up more 20-inch or 24-inch blocks in a day with two men than you can lay up with one man using 16-inch blocks, but get out your pencil and figure the cost and you will see where you will be dollars ahead if you buy an Improved X-L-ALL Cement Block Machine making blocks 16 inches long and to build either an 8-inch, 10-inch or 12-inch wall. If you want something thicker than a 12-inch wall, you can use two 8-inch blocks or one 10-inch and one 8-inch, etc., thus making the wall of any width required. An 8-inch wall is sufficiently heavy for one and two-story residences, small store buildings, etc., but where heavier work is required for larger buildings, use 10-inch blocks for foundation work and 8-inch blocks for the walls of the structure. Large store buildings or three-story residences or flat buildings should be made with 12-inch foundations, 10-inch blocks above the water table to the second story, completed with 8-inch blocks. It is possible to make these several sizes on the Improved X-L-ALL and the face of every sized block as shown in the wall will be 8x8x16 inches. Heretofore there has been some objection raised to using these three sizes of blocks in one wall, because very few people knew how to lay them in the wall and fill out the corners and still have the seam of the wall in line. We have overcome this difficulty, as you will note from diagram shown on pages 53 and 54. With the special attachment we furnish, you can make blocks with our machine to build up a corner on a 12-inch wall by using an 8x8x16-inch block on the corner of the first course, a filler block, 4x4x8 inches, which is made on our regular combination outfit, and on the second course put in the 8x8x16-inch block the opposite way and use the 4x4x8-inch filler.

The Improved X-L-ALL Cement Block Machines are made of the very best grade of cast iron and the best steel and are built with thoroughly modern and up to date machinery and tools, by high grade machinists. Every machine is erected, tested and inspected at the factory. They are then painted and packed for shipment and a record kept of every machine. Every machine bears a serial shop number which is stamped on the steel rocker shaft. Each part used in the construction of the machine has a pattern number, so that any repair or part can be easily ordered by the pattern number. All repairs or parts will fit the machine as they are made with a jig, and we guarantee that all parts are absolutely interchangeable.

With the Improved X-L-ALL Cement Block Machine, Size 8x8x16 Inches, We Furnish the Following Outfit of Face Plates and Attachments for Making Either Hollow or Solid Concrete Building Blocks, Size 8x8x16 Inches



The above illustration shows a rear view of the Improved X-L-ALL Combination Cement Block Outfit. The machine is adjustable, permitting attachments to be used to make three different sized blocks. Note how easily the cores are withdrawn. No side strain, no tilting. Everything absolutely true.

1 Plain Face Plate for making whole blocks, 8x8x16 inches.
1 Plain Face Plate for making half and quarter blocks.
1 Rock Face Plate for making whole blocks, 8x8x16 inches.
1 Rock Face Plate for making halves and quarters.
1 Right Hand Skeleton End Door (for all sizes.)
1 Left Hand Skeleton End Door (for all sizes.)
1 Right Hand End Attachment, plain design, 8x8 inches.
1 Left Hand End Attachment, plain design, 8x8 inches.
1 Right Hand End Attachment, rock design, 8x8 inches.
1 Left Hand End Attachment, rock design, 8x8 inches (for return corners and porch and pier work.)
1 Right Hand End Attachment, core design.
1 Left Hand End Attachment, core design (for making regular wall blocks, cored on both ends.)
1 Skeleton Rear Wall Frame (for all sizes.)
1 Rear Wall Plate for 8x8x16-inch blocks.
1 Skeleton Front Wall or Frame (for all sizes.)
1 Front Wall Plate for 8x8x16-inch pallets.
2 Rear Core Gates.
2 Core Gates for pallets.
1 Dividing Plate to make core ends on half blocks.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Steel Plate, 8x7¾ inches, for forming inside corners.
1 Hook for withdrawing dividing plates.
1 Sample Wood Pallet.
1 Cast Iron Pallet.
1 Steel Pallet.
1 Dividing Plate to make core ends on quarter blocks.
1 Graduated Bar for making halves and quarters and angle blocks.
1 Steel Dividing Plate for making gable blocks.
1 Steel Striker.
1 Steel Carrier.
1 Double End Tamper.

A complete outfit to suit your requirements depends upon the number of blocks you wish to turn out daily, also the different styles of faces and extra attachments, such as bay windows, circles, etc. We furnish the list, as itemized above, with the machine, at the price quoted. Anything in the way of additional face plates, bay window attachments, course block attachments, angles and circles, etc., are not included with the machine or outfit, but are sold as extras at prices quoted. Additional parts may be purchased at any time and you can add to your outfit as your business demands it and experience shows just what parts you need to complete your outfit. We do not charge the usual exorbitant price for parts or repairs; instead, they are priced on the same basis as our other goods. By referring to the list of parts that we furnish with the machine you can readily see that you would have an outfit that would enable you to make blocks with two different designs of faces and each design can be made in half blocks and quarter blocks. You can make inside corners, outside or return corners, joist blocks, regular wall blocks, blocks for foundation of inner walls, gable blocks, porch piers and chimney blocks, door and window frame blocks; in fact, any kind of a block required on an ordinary residence, store building, church or other buildings that can be made with 8-inch building blocks. We furnish a sample wood pallet, but do not recommend the use of wood pallets unless you have a small job of work to do. It will be by far the cheapest in the long run for you to buy iron or steel pallets.

The Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, is so constructed that either steel, cast iron or wood pallets may be used. We recommend our pressed steel pallet. The steel pallet is made for the 8x8x16-inch size only and we use No. 14-gauge cold rolled sheet steel. The pallets are stamped by dies under enormous pressure. They will not warp, shrink or break in handling. They will not warp or crack the block. They are heavy enough, so that they will not spring or bend.

We manufacture cast iron pallets for all three sizes of machines. With every machine we send out a sample wood pallet. We have had numerous inquiries for wood pallets, and to meet the demands of the trade in certain sections of the country we have had the Improved X-L-ALL Machines made to accommodate wood pallets. If you are building a small building, putting in a foundation or doing any job of work where only a small quantity of blocks is required, you can make your own wood pallets, and in doing so the expense incurred will not be very heavy. We would not recommend wood pallets for any contractor or builder or manufacturer of cement blocks who manufactures blocks very extensively. The wood pallets are liable to warp and then they must be thrown away. Money spent for either steel or cast iron pallets is well invested. They will never warp or shrink and are cheaper in the long run.

Remember that all three sizes of the Improved X-L-ALL Combination Cement Block Machine are interchangeable. In other words, the stand or base and the skeleton frame are one and the same with each outfit. If you purchase an 8x8x16-inch size of this machine, you can at any future time buy the set of plates and attachments to make 8x10x16-inch blocks or 8x12x16-inch blocks and use them with this machine. You will then have three complete machines in one and at a price considerably less than any other manufacturer or dealer would sell any one single size of machine. This saving ought to be well worth your careful consideration. Remember, every Improved X-L-ALL Combination Concrete Block Machine is fully warranted. It is sold to you under thirty days' trial. If the machine does not prove entirely satisfactory, it can be returned to us at our expense and we will refund your money.

Refer to pages 23 to 25 for illustrations of hollow concrete blocks, size 8x8x16 inches, made on the Standard and Improved X-L-ALL Cement Block Machines. The size of the blocks, the size of the cores is exactly the same as made on the Standard X-L-ALL Machines. We use the same face plate in all of these machines.

Price List of Improved X-L-ALL Hollow Cement Block Machine, Size 8x8x16 Inches. (Interchangeable with Improved X-L-ALL, Sizes 8x10x16 and 8x12x16 Inches)

With each Improved X-L-ALL Cement Block Machine, we furnish two styles of face plates for whole blocks, half and quarter blocks (four face plates in all). We have made these up in a number of different outfits. We will furnish any two different designs of face plates (plate for whole blocks and another plate for halves and quarters) and end doors to match the faces.

No. 63A301 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, and one sample steel pallet, one sample cast iron pallet and one sample wood pallet. Shipping weight, about 500 pounds. Price........... **$41.00**

No. 63A303 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks and halves and quarters, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 600 pounds. Price.... **$46.50**

No. 63A305 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, halves and quarters, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and twenty-five all steel pallets, and bay window attachment to match above faces. Weight, about 650 pounds. Price.. **$50.25**

No. 63A307 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 900 pounds. Price................ **$65.50**

No. 63A309 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and 100 steel pallets, also bay window attachment to match above faces. Weight, about 950 pounds. Price.. **$69.25**

No. 63A311 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and twenty-five cast iron pallets. Weight, about 675 pounds. Price........ **$46.50**

No. 63A313 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular equipment, also one sample wood pallet, one steel pallet and twenty-five cast iron pallets, also bay window attachment to match above faces. Weight, about 715 pounds. Price.. **$50.25**

No. 63A315 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and 100 cast iron pallets. Weight, about 1,240 pounds. Price..................... **$65.50**

No. 63A317 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and 100 cast iron pallets, also bay window attachment to match above faces. Weight, about 1,290 pounds. Price.. **$69.25**

We can furnish any two styles or designs of face plates wanted. The plain face and rock face are most commonly used. If you want an outfit made up with plain face and panel face, so specify.

No. 63A319 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one sample steel pallet and twenty-five cast iron pallets. Weight, about 675 pounds. Price................ **$46.50**

(Continued on following page.)

Price List of Improved X-L-ALL Machine, 8x8x16 Inches—Continued

No. 63A321 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 650 pounds. Price........................**$46.50**

No. 63A323 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one sample steel pallet and 100 cast iron pallets. Weight, about 1,240 pounds. Price......................**$65.50**

No. 63A325 Improved X-L-ALL Cement Block Machine, size 8x8x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 900 pounds. Price............................**$65.50**

Price List of Extras and Attachments for the Improved X-L-ALL Cement Block Machine, Size 8x8x16 Inches

No. 63A151	Plain Face Plate to make whole blocks. Price, each	**$2.25**
No. 63A152	Plain Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A326	Plain End Door, right hand. Price, each	**1.00**
No. 63A327	Plain End Door, left hand. Price, each	**1.00**
No. 63A155	Medium Rock Face Plate to make whole blocks. Price, each	**2.25**
No. 63A156	Medium Rock Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A330	Medium Rock End Door, right hand. Price, each	**1.00**
No. 63A331	Medium Rock End Door, left hand. Price, each	**1.00**
No. 63A157	Heavy Rock Face Plate to make whole blocks. Price, each	**2.25**
No. 63A158	Heavy Rock Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A159	Shallow Rock Face Plate to make whole blocks. Price, each	**2.25**
No. 63A160	Shallow Rock Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A161	Rock Face, Tooled Margin Face Plate to make whole blocks. Price, each	**2.25**
No. 63A162	Rock Face, Tooled Margin Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A334	Rock Face, Tooled Margin End Door, right hand. Price, each	**1.00**
No. 63A335	Rock Face, Tooled Margin End Door, left hand. Price, each	**1.00**
No. 63A165	Panel Face Plate to make whole blocks. Price, each	**2.25**
No. 63A166	Panel Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A337	Panel End Door, right hand. Price, each	**1.00**
No. 63A338	Panel End Door, left hand. Price, each	**1.00**
No. 63A169	Cobblestone Face Plate to make whole blocks. Price, each	**2.25**
No. 63A170	Cobblestone Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A340	Cobblestone End Door, right hand. Price, each	**1.00**
No. 63A341	Cobblestone End Door, left hand. Price, each	**1.00**
No. 63A173	Tool Face Plate for making whole blocks. Price, each	**2.25**
No. 63A174	Tool Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A342	Tool End Door, right hand. Price, each	**1.00**
No. 63A343	Tool End Door, left hand. Price, each	**1.00**
No. 63A176	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each	**2.25**
No. 63A177	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each	**2.25**
No. 63A178	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each	**2.25**
No. 63A179	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each	**2.25**
No. 63A180	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each	**2.25**

NOTE—To make half and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4 inches) placed on either end of a whole block, produce very desirable results.

No. 63A332	Broken Ashler End Door, right hand. Price, each	**1.00**
No. 63A333	Broken Ashler End Door, left hand. Price, each	**1.00**
No. 63A182	Ornamental Scroll Design Face Plate for making whole blocks. Price, each	**2.25**
No. 63A183	Ornamental Scroll Design Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A344	Ornamental Scroll Design End Door, right hand. Price, each	**1.00**
No. 63A345	Ornamental Scroll Design End Door, left hand. Price, each	**1.00**
No. 63A185	Ornamental Rope Design Face Plate for making whole blocks. Price, each	**2.25**
No. 63A186	Ornamental Rope Design Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A346	Ornamental Rope Design End Door, right hand. Price, each	**1.00**
No. 63A347	Ornamental Rope Design End Door, left hand. Price, each	**1.00**
No. 63A195	Water Table Face Plate for making whole blocks. Price, each	**2.25**
No. 63A196	Water Table Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A348	Water Table End Door Attachment, to be fitted to plain end door for making right hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for right hand return corner wall. Price, each	**.75**

(Continued on following page.)

Price List of Extras and Attachments, Improved X-L-ALL Machine, 8x8x16 Inches—Continued

No. 63A349 Water Table End Door Attachment, to be fitted to core end door for making left hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for the left hand return corner wall. Price, each $0.75

No. 63A351 Circle Face Plate, plain design, with two end door attachments for making 8-foot Radius blocks, size 8x8x16 inches. Price, complete.............................. 3.50

No. 63A352 Circle Face Plate, plain design, with two end door attachments for making 10-foot Radius blocks, size 8x8x16 inches. Price, complete.............................. 3.50

No. 63A353 Circle Face Plate, plain design, with two end door attachments for making 12-foot Radius blocks, size 8x8x16 inches. Price, complete 3.50

No. 63A355 Circle Face Plate, rock design, with two end door attachments for making 8-foot Radius blocks, size 8x8x16 inches. Price, complete.............................. 3.50

No. 63A356 Circle Face Plate, rock design, with two end door attachments for making 10-foot Radius blocks, size 8x8x16 inches. Price, complete 3.50

No. 63A357 Circle Face Plate, rock design, with two end door attachments for making 12-foot Radius blocks, size 8x8x16 inches. Price, complete.............................. 3.50

No. 63A100 Cast Iron Pallets for 8x8x16-inch blocks. Weight, 7 pounds. Price, each.. .25

No. 63A200 Steel Pallets for 8x8x16-inch blocks. Price, each .... .26

No. 63A350 Steel Carrier. Price, each.. .75

No. 63A1100 Double End Tamper. Price, each.................................... .75

Refer to pages 22 and 23 for illustrations of X-L-ALL Face Plates for these machines.

Attachments for Making 4-Inch Course Blocks on the Improved X-L-ALL Cement Block Machine, Size 8x8x16 Inches

We can furnish a double face plate and set of special end doors and attachments for making hollow blocks 4 inches high, 8 inches wide (in the wall) and 16 inches long on the Improved X-L-ALL 8x8x16-inch Cement Block Machine. This outfit consists of a double face plate, with a groove running through the center lengthwise, into which the special inside pallet rests. This face plate is made with two different designs. One plate has rock face on the lower half and a plain face on the upper half of the plate. With this double face plate we furnish two special end doors which are divided into two designs. One half of each door is rock face and the other half plain face to match the face plate. To make return corners or blocks with both ends of the same design as the face, use the two special doors furnished with the outfit, but for making regular wall blocks which should be cored on both ends we furnish you with four cast iron end attachments, which are placed in the end of the machine over the special end doors, thereby forming a groove or core on both ends of these 4-inch course blocks for laying up in the wall. There is also required a dividing pallet for dividing the two styles of faces. We furnish two of these blind or dividing pallets with each outfit. If you find you have use for many of these 4-inch course blocks, you would probably require twenty-five or more of these dividing pallets. The lower block is formed on the regular pallet furnished with the machine. We also furnish with the outfit a double face plate of the same design for making half and quarter blocks (4x8-inch and 4x4-inch blocks). The regular outfit for plain and rock face consists of the following:

1 Double Face Plate for making two designs of 4-inch course blocks, 4x8x16 inches, with plain face and rock face combination.
1 Double Face Plate of the same design, for making half and quarter blocks.
1 Special Right Hand End Door, half rock and half plain face.
1 Special Left Hand End Door, half rock and half plain face.
4 Cast Iron End Attachments for forming core end opening in blocks.
2 Special Cast Iron Dividing Pallets, 8x16 inches.

See pages 26 and 27 for illustrations of 4-Inch Combination Course Block Attachments.

No. 63A390 Set of Attachments for making 4-inch course blocks with plain and rock face, for the Improved X-L-ALL Cement Block Machine, size 8x8x16 inches. Weight, about 150 pounds. Price.. $8.00

No. 63A392 Set of Attachments for making 4-inch course blocks with panel and tool face, for the Improved X-L-ALL Cement Block Machine, size 8x8x16 inches. Weight, about 150 pounds. Price.. 8.00

No. 63A394 Special Cast Iron Dividing Pallets, 8x16 inches, for making 4-inch course blocks. Price, each.. .25

NOTE—4-inch course blocks make a most desirable style of rock to use on any building. Lay a course of 8-inch blocks, rock face design, and then lay a course of 4-inch blocks, either plain face or tool face, or reverse the style of the 4-inch and 8-inch blocks and lay up these courses, alternating with 4-inch and 8-inch blocks, and you have a handsome wall. Many of our customers buy these special dividing plates in lots of 100 at a time. The number you will require will depend on the number of machines and men you work.

Bay Window Attachments for the 8x8x16-Inch Size of the Improved X-L-ALL Cement Block Machine

We can furnish a special bay window attachment which consists of an adjustable face plate for making any angle ranging from 20 to 80 degrees. These attachments make both outside and inside angles. It requires a different face plate and set of attachments for each design of face. We can furnish these bay window angle attachments in either plain face, rock face, panel face, tool face, cobblestone face, or rock face with tooled marginal edge, as wanted.

The face plate used for this adjustable bay window attachment can also be used for making a three-quarter length block with the regular machine outfit. For instance, the rock face adjustable bay window attachment for the 8x8x16-inch Improved X-L-ALL Cement Block Machine will make a regular building block 12 inches long with one core. Three-quarter blocks are very handy to use in the wall, one block of this size taking the place of two smaller fractional blocks.

No. 63A360 Adjustable Bay Window Angle Attachments for Improved X-L-ALL Cement Block Machine, size 8x8x16 inches. Be sure and specify style of face plate wanted. Price. . .**$3.75**

MAKES MORE BLOCKS WITH LESS EXPENSE THAN ON ANY OTHER MACHINE.

Greenville, Ala.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I can say that I have seen several cement block machines, but this X-L-ALL is better than any. Think I can make more on it at less expense than any other. Haven't finished any building yet but when I do I will send you a photo. Yours truly, JASPER A. JONES.

CAN SELL ALL THE BLOCKS HE MAKES.

Troy Mills, Iowa.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to yours of the 23rd, would say that the cement block machine we purchased from you gives satisfaction. We are making blocks for the public and can sell all we make.

Yours truly, J. S. FLOYD.

DOES BETTER WORK THAN $300.00 MACHINES.

R. F. D. No. 1, Worthington, Indiana.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Your express shipment of castings arrived O. K. Will try to answer a few of your questions regarding cement block machine purchased from you. This machine does not make quite as many blocks as some others where they do not face down, but the blocks are of better quality, as they do not crack as the cores are extracted. This machine will do the same work as a $300.00 machine will do on this size block and do it as well. It is a good investment for anyone where there is any demand for brick or stone foundations, etc. You are at liberty to use my name if it will be of any service to you.

This is my formula for making blocks for building or foundations: Put into mould a depth of one inch mixture of one or two parts cement and two parts sand; then finish block with one to five; that is, one part cement and five parts river gravel or fine stone. With this formula I find the core extracts better, but for blocks for rough work, one to six is counted a very good block, but the operator will have to be very careful in making them or they will crack. If there is anything more I can do for you I will gladly do it.

Yours very truly, JAS. S. GWINN.

DELIGHTED WITH THE ENTIRE OUTFIT.

Sears, Ill., R. F. D. No. 1, Feb. 18, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I received your inquiry about my X-L-ALL Cement Block Machine. The machine is all right and makes as good blocks as any machine that I have ever seen. I also purchased your bay window attachments and wish to state that I am well pleased with the entire outfit.

Yours very truly, JOHN A. NELSON.

SAYS WE NEEDN'T HESITATE TO RECOMMEND THE X-L-ALL.

Ninety-Six, S. Car., Jan. 4, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—The X-L-ALL Cement Block Machine is O. K. You need not hesitate to recommend it.

Yours truly, W. H. HOLLAND, M. D.

MOST PROFITABLE INVESTMENT HE EVER MADE.

Lake City, Mich., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Kind Friends:—I have never invested money in anything that doubled as fast as in the X-L-ALL Cement Block Machine. I have only 175 pallets and need seventy-five more to complete my outfit to do a full day's work. with two men. I don't believe I am far behind the record. Two of us mixed one-fourth yard of concrete on the board, and from the time the first shovelful went into the machine till the last block was on the pallet was fifteen minutes and we had twenty blocks without a check in them. We have also made the run of five blocks in three minutes. By laying all this hurry up time aside, two men with any hustle to them can run out from 200 to 250 blocks per day with the X-L-ALL Cement Block Machine. I am well satisfied that I have one of the best cement block machines ever made. Yours truly, K. A. MATTICE.

MAKES PERFECT BLOCKS WITH A MACHINE WHICH COST HALF THE PRICE ASKED FOR OTHER MAKES.

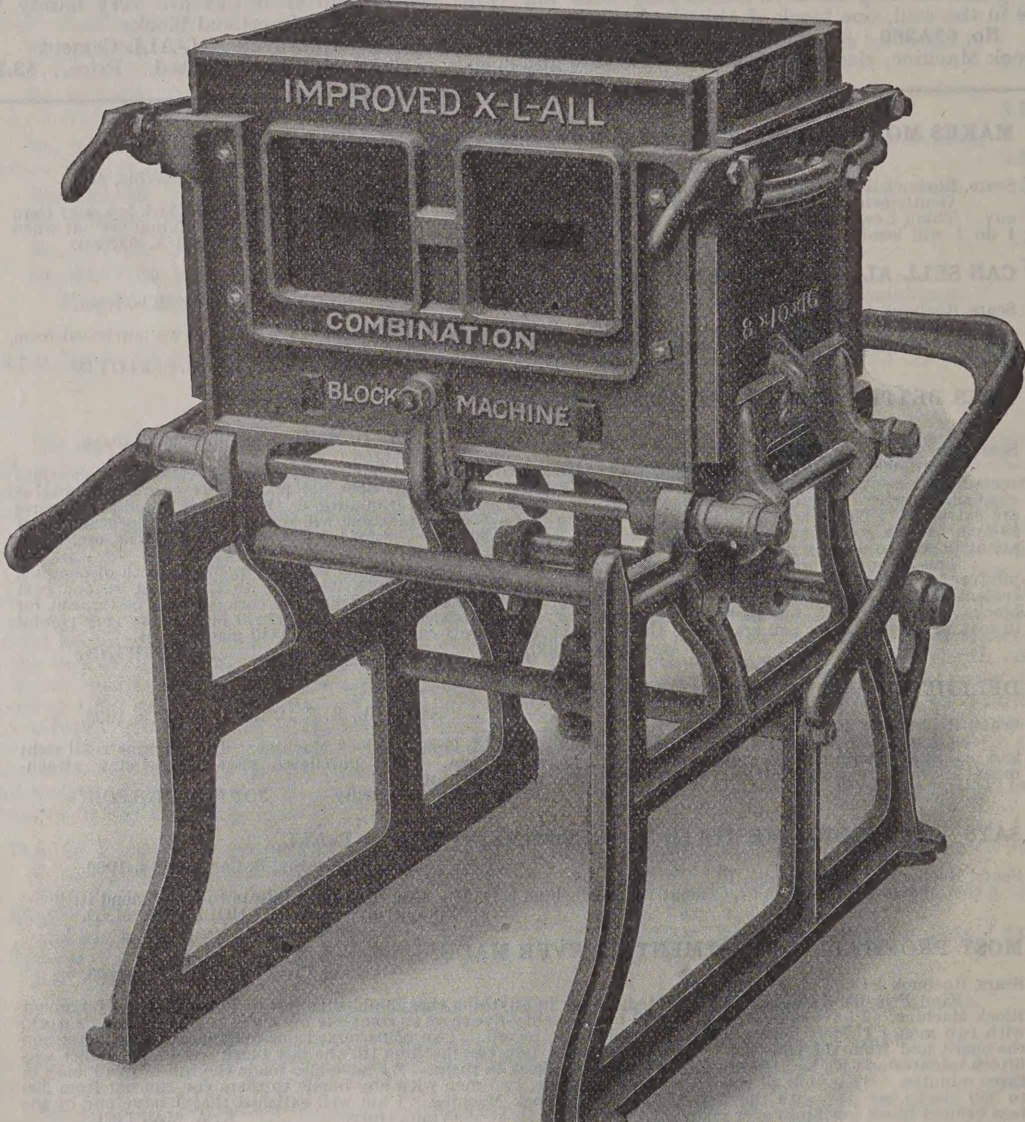
Hemlock, Mich., Dec. 1, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—The X-L-ALL Cement Block Machine I purchased of you gives good satisfaction; makes as good blocks as any machine I have looked at. The blocks are perfect in every respect and I saved about one-half on the price, and will say my customers are all well satisfied. Respectfully, WM. E. MOTT,
Contractor and Builder.

The Improved X-L-ALL Combination Hollow Cement Block Machine

SIZE 8x10x16 INCHES



The above illustration shows the 8x10x16-inch size of Improved X-L-ALL Combination Cement Block Machine. This machine is built up on the same stand and skeleton frame as the 8x8x16-inch size, which is fully described in the preceding pages. This machine is interchangeable with the 8-inch and 12-inch Combination X-L-ALL Machines. See page 50 for view of the skeleton frame or stand used for all three sizes of Improved X-L-ALL Combination Block Machines. We also show an illustration of every part included in the extra attachments for changing the machine from one size to another. An 8x10x16-inch hollow concrete block, made on the X-L-ALL Cement Block Machine, weighs about 60 pounds.

EVERY contractor and builder should have a machine or machines to make concrete building blocks for 8-inch, 10-inch and 12-inch walls. We have had the Improved X-L-ALL Cement Block Machines made to meet the requirements of every carpenter, contractor or builder, every user or maker of concrete building blocks, and have built the machine with a view to making the most popular size of blocks now used. Carpenters and contractors tell us that they prefer the 16-inch block. A block of this length builds up in the wall nicely, making it an easy matter to provide opening for joists, sills and studding. They state further that they prefer the 16-inch concrete block because one man can carry the blocks away from the machine and one man can handle and lay them in the wall. We appreciate the fact that every contractor and builder and every manufacturer of concrete blocks has frequent occasion to make blocks for different widths of walls. An 8-inch block is amply strong for foundations of six or seven-room cottages, or for one-story store buildings. Where a larger building is constructed of concrete blocks it would be advisable to use 10-inch blocks for the foundation. Two-story residences, flats and store buildings should have 12-inch foundations and 10-inch walls for the first story and 8-inch blocks for the upper story. With the Improved X-L-ALL Combination Cement Block Machines it is an easy matter for you to make any of these blocks on your machine by simply buying the attachments for the larger sizes. The price of these attachments is but a fraction of the price charged by other manufacturers who sell you a complete machine and outfit of a larger size. The Improved Combination X-L-ALL Machine is so constructed that there is but little expense incurred in buying extra attachments.

In many sections of the country, especially in some of the smaller cities, the building ordinances require a 10-inch foundation and wall. The 8x10x16-inch size Improved Combination X-L-ALL Machine makes a block for a 10-inch wall that one man can handle. This means a saving to you for extra labor. The 8x10x16-inch size Improved Combination X-L-ALL Machine is made for either wood or cast iron pallets. We do not recommend the wood pallet because it is liable to warp. They might be a little cheaper in the beginning, but they will cost you more in the end.

With the Improved X-L-ALL Hollow Cement Block Machine, Size 8x10x16 Inches, We Furnish the Following Outfit of Face Plates and Attachments for Making Either Hollow or Solid Concrete Building Blocks, Size 8x10x16 Inches

1 Plain Face Plate for making whole blocks, 8x10x16 ins.
1 Plain Face Plate for making half and quarter blocks.
1 Rock Face Plate for making whole blocks, 8x10x16 ins.
1 Rock Face Plate for making halves and quarters.
1 Right Hand Skeleton End Door (for all sizes.)
1 Left Hand Skeleton End Door (for all sizes.)
1 Right Hand End Attachment, plain design, 8x10x16 ins.
1 Left Hand End Attachment, plain design, 8x10x16 ins.
1 Right Hand End Attachment, rock design, 8x10x16 ins.
1 Left Hand End Attachment, rock design, 8x10x16 ins. (for return corners and porch and pier work.)
1 Right Hand End Attachment, core design.
1 Left Hand End Attachment, core design (for making regular wall blocks, cored on both ends.)
1 Skeleton Rear Wall Frame (for all sizes.)
1 Rear Wall Plate for 8x10x16-inch blocks.
1 Skeleton Front Door or Frame (for all sizes.)
1 Front Wall Plate, for 8x10x16-inch pallets.
2 Rear Core Gates.
2 Core Gates for pallets.
1 Dividing Plate to make core ends on half blocks.
1 Dividing Plate to make core ends on quarter blocks.
1 Graduated Bar for making halves and quarters and angle blocks.
1 Steel Dividing Plate for making gable blocks.
1 Steel Striker.
1 Steel Carrier.
1 Double End Tamper.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Steel Plate, 8x7¾ inches, for forming inside corners.
1 Hook for withdrawing dividing plates.
1 Sample Wood Pallet.
1 Cast Iron Pallet.
1 Steel Pallet.

With the Improved X-L-ALL Cement Block Machine we furnish the outfit as itemized above, and with this regular outfit you can make either hollow or solid concrete blocks, return corner blocks, regular wall blocks, blocks for a foundation or wall, joist blocks, gable blocks, window frame blocks, door frame blocks, inside corner blocks, outside corner blocks, porch piers and porch columns and chimney blocks. This covers practically every style of block required on any ordinary residence or mercantile building.

A complete outfit depends largely upon the range of work you propose to handle and the number of people that you employ in your factory. We can furnish a very complete line of attachments and extras which are not included with the above list. To make a complete outfit, you should have the bay window attachments for making both inside and outside angles for bay window blocks. These attachments can be furnished in any style face to match the face plate you may have selected and ordered with your machine. We also have a very complete set of attachments for making 4-inch course blocks. These attachments can be furnished in two different combinations, each one of which makes two faces or kinds of blocks. For instance, one combination enables you to make plain face and rock face blocks, either solid or hollow, and either in whole blocks, half blocks or quarters. Another combination enables you to produce the same results with panel face and tool face. Additional parts may be purchased at any time and you can add to your outfit as the demands require. We do not charge the usual exorbitant price for parts or attachments which is generally charged by other manufacturers. All of our attachments, extra faces, ends, etc., are priced on the same low basis as the complete machines.

Remember that all three sizes of the Improved X-L-ALL Combination Cement Block Machine are interchangeable. In other words, the stand or base and the skeleton frame is one and the same with each outfit. If you purchase this 8x10x16-inch size machine, you can at any future time buy the set of plates and attachments to make 8x8x16-inch blocks or 8x12x16-inch blocks and use them with this machine. You will then have three complete machines in one and at a price considerably less than any other manufacturer or dealer asks for one single size of machine. This saving ought to be well worth your careful consideration. Remember, every Improved X-L-ALL Combination Concrete Block Machine is fully warranted. It is sold to you under thirty days' trial. If the machine does not prove entirely satisfactory, it can be returned to us at our expense and we will refund your money.

Price List of Improved X-L-ALL Hollow Cement Block Machine, Size 8x10x16 Inches. (Interchangeable with Improved X-L-ALL, Sizes 8x8x16 and 8x12x16 Inches)

With each Improved X-L-ALL Cement Block Machine we furnish two styles of face plates, for whole blocks and half and quarter blocks (4 plates in all). We have made these up in a number of different outfits. We will furnish any two different designs of face plates (plate for whole blocks and another plate for halves and quarters), end doors to match the faces.

No. 63A401 Improved X-L-ALL Cement Block Machines, size 8x10x16 inches, with choice of any two designs of face plates for whole blocks and halves and quarters, end doors to match, and other attachments as included with regular equipment, and one sample steel pallet, one sample cast iron pallet and one sample wood pallet. Shipping weight, about 550 pounds Price **$49.25**

No. 63A403 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks and halves and quarters, rock face plate, for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 625 pounds. Price.**$54.00**

No. 63A405 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, halves and quarters, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachment, also one sample wood pallet, one cast iron pallet and twenty-five all steel pallets and bay window attachments to match all faces. Weight, about 800 pounds. Price..**$58.00**

No. 63A407 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 1,200 pounds. Price..........**$80.50**

No. 63A409 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and 100 steel pallets, also bay window attachment to match above faces. Weight, about 1,250 pounds. Price...**$84.50**

No. 63A411 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and twenty-five cast iron pallets. Weight, about 750 pounds. Price.......**$54.00**

No. 63A413 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and twenty-five cast iron pallets, also bay window attachment to match above faces. Weight, about 800 pounds. Price **$58.00**

No. 63A415 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and 100 cast iron pallets. Weight, about 1,500 pounds. Price.............**$80.50**

No. 63A417 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and 100 cast iron pallets, also bay window attachment to match above faces. Weight, about 1,550 pounds. Price..**$84.50**

We can furnish any two styles or designs of face plates wanted. The plain face and rock face are most commonly used. If you want an outfit made up with plain face and panel face, so specify.

No. 63A419 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one sample steel pallet and twenty-five cast iron pallets. Weight, about 750 pounds. Price...............**$54.00**

No. 63A421 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 625 pounds. Price......................**$54.00**

No. 63A423 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one sample steel pallet and 100 cast iron pallets. Weight, about 1,500 pounds. Price.....................**$84.50**

No. 63A425 Improved X-L-ALL Cement Block Machine, size 8x10x16 inches, with choice of any two designs of face plates for whole blocks, halves and quarters, end doors to match and other attachments as included with regular equipment, with one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 1,175 pounds. Price **$84.50**

Price List of Extras and Attachments for the Improved X-L-ALL Cement Block Machine, Size 8x10x16 Inches

No. 63A151	Plain Face Plate to make whole blocks. Price, each	$2.25
No. 63A152	Plain Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A426	Plain End Door, right hand. Price, each	1.30
No. 63A427	Plain End Door, left hand. Price, each	1.30
No. 63A155	Medium Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A156	Medium Rock Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A430	Medium Rock End Door, right hand. Price, each	1.30
No. 63A431	Medium Rock End Door, left hand. Price, each	1.30
No. 63A157	Heavy Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A158	Heavy Rock Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A159	Shallow Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A160	Shallow Rock Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A161	Tooled Margin Rock Face Plate to make whole blocks. Price, each	2.25
No. 63A162	Tooled Margin Rock Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A434	Tooled Margin Rock End Door, right hand. Price, each	1.30
No. 63A435	Tooled Margin Rock End Door, left hand. Price, each	1.30
No. 63A165	Panel Face Plate to make whole blocks. Price, each	2.25
No. 63A166	Panel Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A437	Panel End Door, right hand. Price, each	1.30
No. 63A438	Panel End Door, left hand. Price, each	1.30
No. 63A169	Cobblestone Face Plate to make whole blocks. Price, each	2.25
No. 63A170	Cobblestone Face Plate to make half and quarter blocks. Price, each	2.25
No. 63A440	Cobblestone End Door, right hand. Price, each	1.30
No. 63A441	Cobblestone End Door, left hand. Price, each	1.30
No. 63A173	Tool Face Plate for making whole blocks. Price, each	2.25
No. 63A174	Tool Face Plate for making half and quarter blocks. Price, each	2.25
No. 63A442	Tool End Door, right hand. Price, each	1.30
No. 63A443	Tool End Door, left hand. Price, each	1.30
No. 63A176	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each	2.25
No. 63A177	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each	2.25
No. 63A178	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each	2.25
No. 63A179	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each	2.25
No. 63A180	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each	2.25

NOTE—To make half and quarter blocks for broken ashler work, use regular rock face plate for making half and quarter blocks. Two quarter blocks (4-inch) placed on either end of a whole block produce very desirable results.

No. 63A432	Broken Ashler End Door, right hand. Price, each	1.30
No. 63A433	Broken Ashler End Door, left hand. Price, each	1.30
No. 63A182	Ornamental Scroll Design Face Plate for making whole blocks. Price, each	2.25
No. 63A183	Ornamental Scroll Design Face Plate for making half and quarter blocks. Price, each	2.25
No. 63A444	Ornamental Scroll Design End Door, right hand. Price, each	1.30
No. 63A445	Ornamental Scroll Design End Door, left hand. Price, each	1.30
No. 63A185	Ornamental Rope Design Face Plate for making whole blocks. Price, each	2.25
No. 63A186	Ornamental Rope Design Face Plate for making half and quarter blocks. Price, each	2.25
No. 63A446	Ornamental Rope Design End Door, right hand. Price, each	1.30
No. 63A447	Ornamental Rope Design End Door, left hand. Price, each	1.30
No. 63A195	Water Table Face Plate for making whole blocks. Price, each	2.25
No. 63A196	Water Table Face Plate for making half and quarter blocks. Price, each	2.25
No. 63A448	Water Table End Door Attachment, to be fitted to core end door for making right hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for right hand return corner wall. Price, each	1.00
No. 63A449	Water Table End Door Attachment, to be fitted to core end door for making left hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for the left hand return corner wall. Price, each	1.00
No. 63A451	Circle Face Plate, plain design with two end door attachments for making 8-foot Radius blocks, size 8x10x16 inches. Price, complete	4.00
No. 63A452	Circle Face Plate, plain design with two end door attachments for making 10-foot Radius blocks, size 8x10x16 inches. Price, complete	4.00
No. 63A453	Circle Face Plate, plain design with two end door attachments for making 12-foot Radius blocks, size 8x10x16 inches. Price, complete	4.00
No. 63A455	Circle Face Plate, rock design, with two end door attachments for making 8-foot Radius blocks, size 8x10x16 inches. Price, complete	4.00
No. 63A456	Circle Face Plate, rock design, with two end door attachments for making 10-foot Radius blocks, size 8x10x16 inches. Price, complete	4.00
No. 63A457	Circle Face Plate, rock design, with two end door attachments for making 12-foot Radius blocks, size 8x10x16 inches. Price, complete	4.00
No. 63A400	Cast Iron Pallets for 8x10x16-inch blocks. Weight, 10 pounds. Price, each.	.30
No. 63A450	Steel Carrier. Price, each	.75
No. 63A1100	Double End Tamper. Price, each	.75

Attachments for Making 4-Inch Course Blocks on the Improved X-L-ALL Hollow Cement Block Machine, Size 8x10x16 Inches

We can furnish a double face plate and set of special end doors and attachments for making hollow blocks, 4 inches high, 10 inches wide (in the wall) and 16 inches long, on the Improved X-L-ALL Cement Block Machine. This outfit consists of a double face plate with a groove running through the center lengthwise into which the special inside pallet rests. This face plate is made with two different designs. One plate has rock face on the lower half and a plain face on the upper half of the plate. With this double face plate we furnish two special end doors which are divided into two designs. One half of each door is rock face and the other half plain face to match the face plate. To make return corners or blocks with both ends of the same design as the face, use the two special doors furnished with the outfit; but for making regular wall blocks, which should be cored on both ends we furnish you with four cast iron end attachments to be placed in the end of the machine over the special end doors, thereby forming a groove or core on both ends of these 4-inch course blocks for laying up in the wall. A dividing pallet is also required with each outfit. If you find you have use for many of these 4-inch course blocks, you would probably require twenty-five or more of these dividing pallets. The lower block is formed on the regular pallet furnished with the machine. We also furnish with this outfit a double face plate of the same design for making half and quarter blocks (4x10-inch and 4x4-inch blocks). The regular outfit for plain and rock face consists of the following:

1 Double Face Plate for making two designs of 4-inch course blocks, 4x10x16 inches, with plain face and rock face combinations.
1 Double Face Plate of the same design for making half and quarter blocks.
1 Special Right Hand End Door, half rock and half plain face.
1 Special Left Hand End Door, half rock and half plain face.
4 Cast Iron End Attachments for forming core end opening in blocks.
2 Special Cast Iron Dividing Pallets, 10x16 inches.

No. 63A490 Set of Attachments for making 4-inch course blocks with plain and rock face, for the Improved X-L-ALL Cement Block Machine, size 8x10x16 inches. Weight, about 150 pounds. Price........ **$8.60**

No. 63A492 Set of Attachments for making 4-inch course blocks with panel and tool face, for the Improved X-L-ALL Cement Block Machine, size 8x10x16 inches. Weight, about 150 pounds. Price........ **8.60**

No. 63A494 Special Cast Iron Dividing Pallets, 10x16 inches, for making 4-inch course blocks. Price, each........ **.30**

NOTE—4-inch course blocks make a most desirable style of rock to use on any building. Lay a course of 8-inch blocks, rock face design, and then lay a course of 4-inch blocks, either plain face or tool face, or reverse the style of the 4-inch and 8-inch blocks and lay up these courses alternating with 4-inch and 8-inch blocks and you have a handsome wall. Many of our customers buy these special dividing pallets in lots of 100 at a time.

Bay Window Attachments for the 8x10x16-Inch Size of the Improved X-L-ALL Cement Block Machine

We can furnish a special bay window attachment, which consists of an adjustable face plate for making any angle ranging from 20 to 80 degrees. These attachments make both outside and inside angles. It requires a different face plate and set of attachments for each design of face. We can furnish these bay window angle attachments in either plain face, rock face, panel face, tool face, cobblestone face or rock face with tooled marginal edge, as wanted.

The face plate used for this adjustable bay window attachment can also be used for making a three-quarter length block with the regular machine outfit. For instance, the rock face adjustable bay window attachment for the 8x10x16-inch Improved X-L-ALL Cement Block Machine will make a regular building block 12 inches long, with one core. Three-quarter blocks are very handy to use in the wall, one block of this size taking the place of two smaller fractional blocks.

No. 63A460 Adjustable Bay Window Angle Attachments for Improved X-L-ALL Cement Block Machine, size 8x10x16 inches. Be sure to specify style of face plate wanted. Price.... **$4.25**

X-L-ALL THE BEST OF FOUR MAKES. HAVE MADE AND SOLD 10,000 BLOCKS AND HAVE ORDERS FOR 10,000 MORE.

DOVE & MILLER,
Manufacturers of
Cement Building Blocks.

Woodstock, Ill., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—We have made over 12,000 blocks with your X-L-ALL Cement Block Machine, size 8x8x16 inches, that we purchased from you last June and have sold about 10,000 of them and have orders for about 10,000 on hand to fill. Every block made has given perfect satisfaction. We have sold blocks for two large houses, both of which are being finished. We think the X-L-ALL Cement Block Machine is the best one made, and we have used five other makes of machines. The X-L-ALL suits us best.

Respectfully, DOVE & MILLER CEMENT BLOCK CO.

AS GOOD AS MACHINES COSTING $100.00.

Ossian, Ind., Dec. 24, 1906.
R. F. D. No. 1.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I received your X-L-ALL Cement Block Machine all right and like it first rate. It is just as good as any machine that cost $100.00 or more. The machine works satisfactorily and makes good blocks.

Yours very truly, M. H. SHOE.

A CUSTOMER'S OPINION
OF THE X-L-ALL
CEMENT BLOCK MACHINE

Walloon Lake, Mich., June 15, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—Replying to your favor of recent date, will say that I received the cement block machine in due time and am pleased to say that it far exceeded my expectations. I had examined and priced many other machines before giving you my order, and must say, after comparing prices of other machines with your X-L-ALL, I was somewhat timid about ordering one, owing to the vast difference in the prices, and fearing that I might receive a cheap, inferior machine. However, as I had bought several hundred dollars' worth of goods from you while you were still in Minneapolis, and so far had never received anything but first class goods, I took it for granted that I would not be taking any chances in ordering a machine. To say that I am pleased with the machine does not express it.

I find one fine quality the machine has over any of the high priced machines that I have examined, is, that it makes the block face down, enabling you to make the face of fine material and the body of the block of coarser material, thus making a first class block. You ask me to give you my formula and my experience in block making; also to state what trouble I have experienced and how I overcame it. I must say that my experience has been of short duration; but, nevertheless, I find that I am making a much finer block than I have been able to find in the different towns that I have visited. As to trouble, I have not experienced any to speak of. However, I have found that if the cement is too fresh it will cause the blocks to crack. Cement should not be less than thirty days old before using My formula for making blocks is as follows: For facing, cement one part, screened sand, two parts; for body of block, cement one part, sand three parts, aggregate four parts. For complete block (face and body), cement one part, sand three parts. The blocks should remain on the pallets for thirty-six hours, and after twenty-four hours should be kept wet and covered from the sun and currents of air. In six or eight days they are seasoned and in two weeks can be made in the wall. In cool weather the drying is retarded; they will require less water but more time to be ready for the wall. By all means, do not try to guess at this work; use a measure for everything but water. This you will learn to gauge by experience.

Yours very truly,
C. J. MIZER.

During the latter part of November we wrote Mr. Mizer again, thinking that after the season's work was over he might have something new to tell us, or possibly might have had some unpleasant experience, either with the machine or in the making of concrete, etc. Mr. Mizer's last letter, which we reproduce here, is self explanatory. S., R. & Co.

Walloon Lake, Mich., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—Replying to yours of the 26th inst., will say I cannot see where I can give you any better testimonial regarding the X-L-ALL Cement Block Machine I purchased of your people than I have already done. I am enclosing a letter I have received and my reply thereto to show you how I feel toward your cement block machine and what interest I take in Sears, Roebuck & Co.

Yours very truly,
C. J. MIZER.

Here is the letter Mr. Mizer received from one of our prospective customers in Pennsylvania. The letter reads:—

Myerstown, Pa., Oct. 22, 1906.

C. J. Mizer, Walloon Lake, Mich.

Dear Sir:—Having read your testimonial in Sears, Roebuck & Co.'s catalogue in regard to the X-L-ALL Cement Block Machine, would be pleased if you would let me know all the particulars about the machine, or is there a machine which you think is better than the X-L-ALL and can you refer me to any party where I can buy a concrete mixer? Do you use a concrete mixer, and what kind and style? I am,

Yours truly,
GEO. H. SMITH.

Now read Mr. Mizer's reply to this letter of inquiry:

Walloon Lake, Mich., Nov. 30, 1906.

Mr. Geo. Smith, Myerstown, Pa.

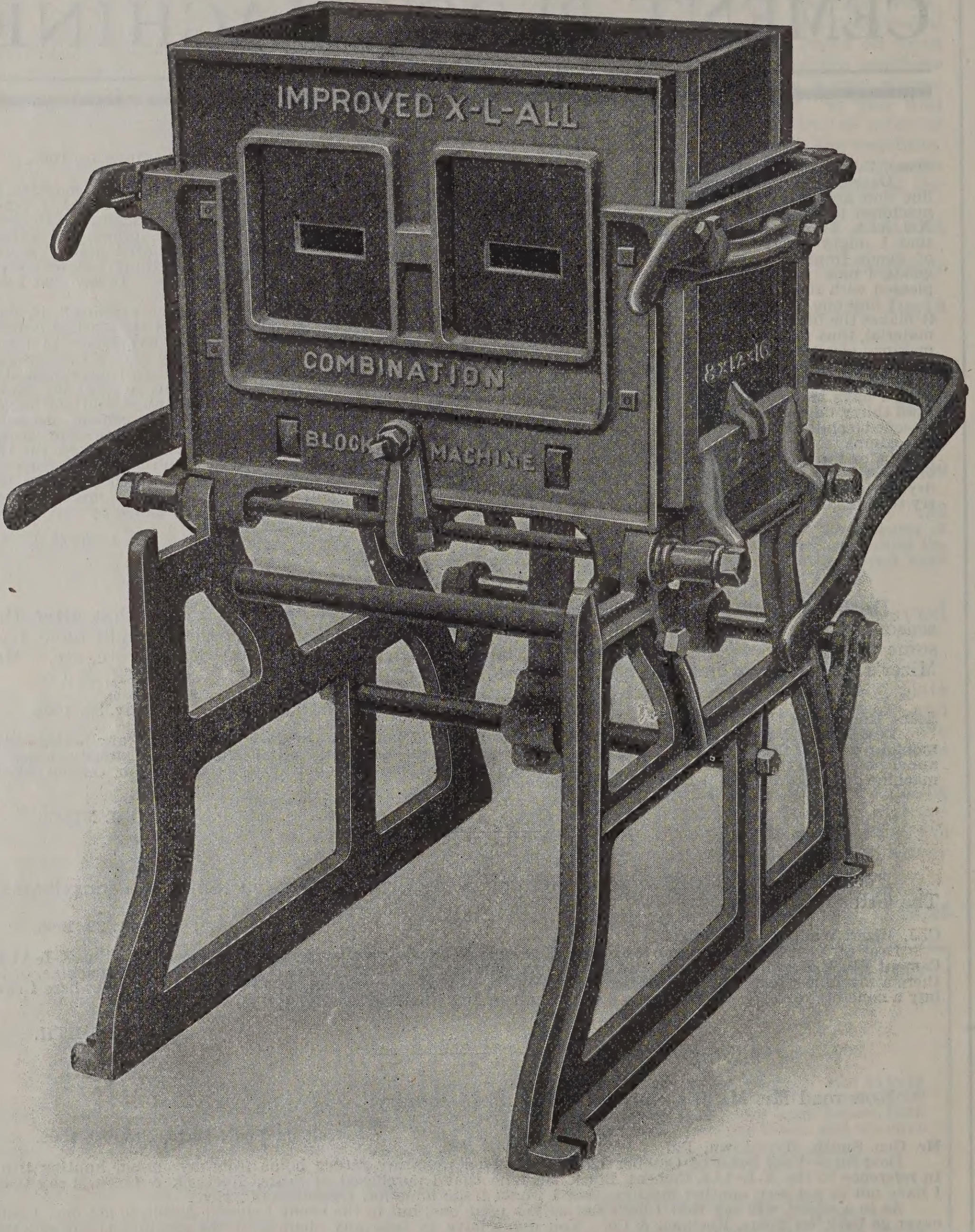
Dear Sir:—Your letter of October 22d just received upon my return home from my annual hunting trip. In reference to the X-L-ALL Cement Block Machine that I purchased of Sears, Roebuck & Co., will say that I have not as yet seen another machine that I would trade mine for, regardless of price.

As to a mixer, will say that I have not as yet used one, but in the event I should decide to get one, I will never go back on Sears, Roebuck & Co. You don't have to take any chances; if the machine is not exactly as represented and perfectly satisfactory, you don't have to keep it.

Yours very truly,
C. J. MIZER.

The Improved X-L-ALL Combination Hollow Cement Block Machine

SIZE 8x12x16 INCHES



We illustrate above the Improved X-L-ALL Combination Cement Block Machine, size 8x12x16 inches. This machine is especially adapted for the use of large contractors and builders. This size machine makes a hollow concrete building block for 12-inch wall. See page 50 for view of skeleton frame or stand used for building all three sizes of Improved X-L-ALL Combination Block Machine. We also show an illustration of every part included in the extra attachments for changing the machine from one size to another. An 8x12x16-inch hollow concrete block made on the X-L-ALL Cement Block Machine weighs about 72 pounds.

THE Improved X-L-ALL Combination Cement Block Machine, size 8x12x16 inches, is built up from the same skeleton frame and stand as used on the 8-inch and 10-inch machines, which have been fully described on the preceding pages. An 8x12x16-inch hollow concrete block made on this machine weighs about 72 pounds. One man can handle these blocks, both from the machine and in laying them up in the wall. The 12-inch block has the same size face as is used on the 8-inch and 10-inch blocks made on the Improved X-L-ALL Machines, namely, 8 inches by 16 inches. This permits of the mortar lines being carried up absolutely true in your walls, no matter whether the walls are 8 inches, 10 inches or 12 inches thick. We give in connection with the Improved X-L-ALL Combination Outfit a diagram showing a method of laying up corners with 12-inch blocks so that the mortar joints will be directly in line with each other. With each combination machine we furnish attachments for making the fillers for laying up the corners. In laying a wall made from 8x12x16-inch blocks, the corner on the first course will be turned with an 8x10x16-inch block and a filler used to bring it out to the 12-inch line in the inside corner. In the second course the 8x12x16-inch block is carried forward half way over the 10-inch block and the return corner made with an 8x8x16-inch block, and a 4x4x8-inch filler used in the inside corner of the wall.

On the following pages we describe and quote prices on attachments for building up other sizes of machines on the 8x12x16-inch size. If you are located in some of the larger cities where the building ordinances require heavy foundations, you will find the 8x12x16-inch size X-L-ALL Improved Cement Block Machine necessary to complete your equipment. This size of machine is used for making blocks for the heaviest of walls. The 8x12x16-inch size Improved X-L-ALL Machine is made for either cast iron or wood pallets. We prefer and recommend the cast iron pallet, and while it may be a little more expensive it will certainly prove a good investment to you. Cast iron pallets will never warp or spring and are therefore less liable to crack the block. We do not recommend wood pallets. At the request of some of our customers, we have had these machines made for wood pallets, and where only a small number of 8x12x16 blocks are wanted, they can be made with wood pallets. If you will use care in selecting a good dry lumber and then watch the pallets so that they do not warp, you can make a block that is absolutely true. Do not attempt to use pallets that have begun to warp or check. A good way to make wood pallets is to saw out three or four grooves about a quarter of an inch deep, lengthwise of the pallet and on the under side before the cleats are nailed on. Another good way to use wood pallets is to have them thoroughly seasoned and then saturate in boiling linseed oil. This will well repay you for the cost and labor of preserving the pallets if you decide to use wood pallets extensively.

With the Improved X-L-ALL Hollow Cement Block Machine, Size 8x12x16 Inches, We Furnish the Following Outfit of Face Plates and Attachments for Making Either Hollow or Solid Concrete Building Blocks, Size 8x12x16 Inches

1 Plain Face Plate for making whole blocks, 8x12x16 ins.
1 Plain Face Plate for making half and quarter blocks.
1 Rock Face Plate for making whole blocks, 8x12x16 ins.
1 Rock Face Plate for making halves and quarters.
1 Right Hand Skeleton End Door (for all sizes.)
1 Left Hand Skeleton End Door (for all sizes.)
1 Right Hand End Attachment, plain design, 8x12x16 ins.
1 Left Hand End Attachment, plain design, 8x12x16 ins.
1 Right Hand End Attachment, rock design, 8x12x16 ins.
1 Left Hand End Attachment, rock design, 8x12x16 inches (for return corners and porch and pier work.)
1 Right Hand End Attachment, core design.
1 Left Hand End Attachment, core design (for making regular wall blocks, cored on both ends.)
1 Skeleton Rear Wall Frame (for all sizes.)
1 Rear Wall Plate for 8x12x16-inch blocks.
1 Skeleton Front Door or Frame (for all sizes.)
1 Front Wall Plate for 8x12x16-inch pallets.
2 Rear Core Gates.
2 Core Gates for pallets.
1 Dividing Plate to make core ends on half blocks.
1 Dividing Plate to make core ends on quarter blocks.
1 Graduated Bar for making halves and quarters and angle blocks.
1 Steel Dividing Plate for making gable blocks.
1 Steel Striker.
1 Steel Carrier.
1 Double End Tamper.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Steel Plate, 8x7¾ inches, for forming inside corners.
1 Hook for withdrawing dividing plates.
1 Sample Wood Pallet.
1 Cast Iron Pallet.
1 Steel Pallet.

A complete outfit suited to your needs depends upon the number of blocks that you turn out daily, also the different style of faces and extra attachments, such as bay windows, circles, etc. We furnish the outfit as itemized above with the machine, and anything in the way of additional face plates, bay window attachments, course block attachments, angles and circles, etc., are not included with the machine or outfit except as extras, at prices quoted. Additional parts may be purchased at any time, and you can add to your outfit as your business demands it and experience shows just what parts you need to complete your equipment. We do not charge the usual exorbitant price for parts or repairs, but price these articles on the same basis as our other goods. By referring to the list of parts that we furnish with the machine you will readily see that we give you an outfit that will enable you to make blocks with two different designs of faces and each design can be made in half blocks and quarter blocks. You can make inside corners, outside or return corners, joist blocks, regular wall blocks, blocks for foundation or inner walls, gable blocks, porch pier and chimney blocks, door and window frame blocks, in fact any kind of a block required on an ordinary residence, store building, church or other buildings that can be made with 8-inch building blocks. We furnish a sample wood pallet, but do not recommend the use of wood pallets unless you have a small job of work to do. It will be by far the cheapest in the end for you to buy iron pallets.

Remember that all three sizes of the Improved X-L-ALL Combination Cement Block Machines are interchangeable. In other words, the stand or base and the skeleton frame is the same with each outfit. If you purchase an 8x12x16-inch size of this machine you can at any future time buy the set of plates and attachments to make 8x8x16-inch blocks or 8x10x16-inch blocks and use them with your machine. You will then have three complete machines in one, and at a price considerably less than any other manufacturer or dealer would sell any one single size of machine. This saving ought to be well worth your consideration.

Remember, every Improved X-L-ALL Combination Concrete Block Machine is fully warranted. It is sold to you under thirty days' trial. If the machine does not prove entirely satisfactory, it can be returned to us at our expense and we will refund your money.

Price List of Improved X-L-ALL Hollow Cement Block Machine, Size 8x12x16 Inches. (Interchangeable with Improved X-L-ALL, Sizes 8x8x16 and 8x10x16 Inches)

With each Improved X-L-ALL Cement Block Machine we furnish two styles of face plates, for whole blocks, half and quarter blocks (four plates in all). We have made these up in a number of different outfits. We will furnish any two different designs of face plates (plate for whole blocks and another plate for halves and quarters) and end doors to match the faces.

No. 63A501 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with choice of any two designs of face plates for whole blocks, half and quarter blocks, end doors to match, and other attachments as included with regular equipment, and one sample steel pallet, one sample cast iron pallet and one sample wood pallet. Shipping weight, about 625 pounds. Price........**$53.75**

No. 63A503 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plates for whole blocks, half and quarter blocks, rock face plates for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 750 pounds. Price......**$61.50**

No. 63A505 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and twenty-five all steel pallets, also bay window attachment to match above faces. Weight, about 800 pounds. Price..**$65.50**

No. 63A507 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 1,275 pounds. Price..........**$87.75**

No. 63A509 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end door to match both faces and regular attachments, also one sample wood pallet, one cast iron pallet and 100 all steel pallets, also bay window attachment to match above faces. Weight, about 1,350 pounds. Price..**$91.75**

No. 63A511 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and twenty-five cast iron pallets. Weight, about 850 pounds. Price........**$61.50**

No. 63A513 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and twenty-five cast iron pallets, also bay window attachment to match above faces. Weight, about 900 pounds. Price..**$65.50**

No. 63A515 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and 100 cast iron pallets. Weight, about 1,700 pounds. Price.............**$87.75**

No. 63A517 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with plain face plate for whole blocks, half and quarter blocks, rock face plate for whole blocks, half and quarter blocks, with end doors to match both faces and regular attachments, also one sample wood pallet, one steel pallet and 100 cast iron pallets with bay window attachments to match above faces. Weight, about 1,750 pounds. Price..**$91.75**

No. 63A519 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with choice of any two designs of face plates for whole blocks, half and quarter blocks, with end doors to match, and other attachments as included with regular equipment, with one sample wood pallet, one sample steel pallet and twenty-five cast iron pallets. Weight, about 750 pounds. Price...............**$61.50**

No. 63A521 Improved X-L-ALL Cement Block Machine size, 8x12x16 inches, with choice of any two designs of face plates for whole blocks, half and quarter blocks, with end doors to match, and other attachments as included with regular equipment, with one sample wood pallet, one cast iron pallet and twenty-five all steel pallets. Weight, about 850 pounds. Price............**$61.50**

No. 63A523 Improved X-L-ALL Cement Block Machine size, 8x12x16 inches, with choice of any two designs of face plates for whole blocks, half and quarter blocks, with end doors to match, and other attachments as included with regular equipment, with one sample wood pallet, one sample steel pallet and 100 cast iron pallets. Weight, about 1,275 pounds. Price.................**$87.75**

No. 63A525 Improved X-L-ALL Cement Block Machine, size 8x12x16 inches, with choice of any two designs of face plates for whole blocks, half and quarter blocks, with end doors to match, and other attachments as included with regular equipment, with one sample wood pallet, one cast iron pallet and 100 all steel pallets. Weight, about 1,700 pounds. Price..................**$87.75**

We can furnish any two styles or designs of face plates wanted. The plain face and rock face are most commonly used. If you want an outfit made up with plain face and panel face, so specify.

Price List of Extras and Attachments for the Improved X-L-ALL Cement Block Machine, Size 8x12x16 Inches

No. 63A151	Plain Face Plate to make whole blocks. Price, each	**$2.25**
No. 63A152	Plain Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A526	Plain End Door, right hand. Price, each	**1.55**
No. 63A527	Plain End Door, left hand. Price, each	**1.55**
No. 63A155	Medium Rock Face Plate to make whole blocks. Price, each	**2.25**
No. 63A156	Medium Rock Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A530	Medium Rock End Door, right hand. Price, each	**1.55**
No. 63A531	Medium Rock End Door, left hand. Price, each	**1.55**
No. 63A157	Heavy Rock Face Plate to make whole blocks. Price, each	**2.25**
No. 63A158	Heavy Rock Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A159	Shallow Rock Face Plate to make whole blocks. Price, each	**2.25**
No. 63A160	Shallow Rock Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A161	Rock Face, Tooled Margin Face Plate to make whole blocks. Price, each	**2.25**
No. 63A162	Rock Face, Tooled Margin Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A534	Rock Face, Tooled Margin End Door, right hand. Price, each	**1.55**
No. 63A535	Rock Face, Tooled Margin End Door, left hand. Price, each	**1.55**
No. 63A165	Panel Face Plate to make whole blocks. Price, each	**2.25**
No. 63A166	Panel Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A537	Panel End Door, right hand. Price, each	**1.55**
No. 63A538	Panel End Door, left hand. Price, each	**1.55**
No. 63A169	Cobblestone Face Plate to make whole blocks. Price, each	**2.25**
No. 63A170	Cobblestone Face Plate to make half and quarter blocks. Price, each	**2.25**
No. 63A540	Cobblestone End Door, right hand. Price, each	**1.55**
No. 63A541	Cobblestone End Door, left hand. Price, each	**1.55**
No. 63A173	Tool Face Plate for making whole blocks. Price, each	**2.25**
No. 63A174	Tool Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A542	Tool End Door, right hand. Price, each	**1.55**
No. 63A543	Tool End Door, left hand. Price, each	**1.55**
No. 63A176	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each	**2.25**
No. 63A177	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each	**2.25**
No. 63A178	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each	**2.25**
No. 63A179	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each	**2.25**
No. 63A180	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each	**2.25**

NOTE—To make half and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a whole block produce very desirable results.

No. 63A532	Broken Ashler End Door, right hand. Price, each	**1.55**
No. 63A533	Broken Ashler End Door, left hand. Price, each	**1.55**
No. 63A182	Ornamental Scroll Design Face Plate for making whole blocks. Price, each.	**2.25**
No. 63A183	Ornamental Scroll Design Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A544	Ornamental Scroll Design End Door, right hand. Price, each	**1.55**
No. 63A545	Ornamental Scroll Design End Door, left hand. Price, each	**1.55**
No. 63A185	Ornamental Rope Design Face Plate for making whole blocks. Price, each	**2.25**
No. 63A186	Ornamental Rope Design Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A546	Ornamental Rope Design End Door, right hand. Price, each	**1.55**
No. 63A547	Ornamental Rope Design End Door, left hand. Price, each	**1.55**
No. 63A195	Water Table Face Plate for making whole blocks. Price, each	**2.25**
No. 63A196	Water Table Face Plate for making half and quarter blocks. Price, each	**2.25**
No. 63A548	Water Table End Door Attachment, to be fitted to core end door for making right hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for right hand return corner wall. Price, each	**1.10**
No. 63A549	Water Table End Door Attachment, to be fitted to core end door for making left hand end of water table design on regular water table face. Makes three-quarter (12-inch) block for the left hand return corner wall. Price, each	**1.10**
No. 63A551	Circle Face Plate, plain design, with two end door attachments for making 8-foot radius blocks, size 8x12x16 inches. Price, complete	**4.00**
No. 63A552	Circle Face Plate, plain design, with two end door attachments for making 10-foot radius blocks, size 8x12x16 inches. Price, complete	**4.00**
No. 63A553	Circle Face Plate, plain design, with two end door attachments for making 12-foot radius blocks, size 8x12x16 inches. Price, complete	**4.00**
No. 63A555	Circle Face Plate, rock design, with two end door attachments for making 8-foot radius blocks, size 8x12x16 inches. Price, complete	**4.00**
No. 63A556	Circle Face Plate, rock design, with two end door attachments for making 10-foot radius blocks, size 8x12x16 inches. Price, complete	**4.00**
No. 63A557	Circle Face Plate, rock design, with two end door attachments for making 12-foot radius blocks, size 8x12x16 inches. Price, complete	**4.00**
No. 63A500	Cast Iron Pallets for 8x12x16-inch blocks. Weight, 12 pounds. Price, each.	**.35**
No. 63A550	Steel Carrier. Price, each	**.75**
No. 63A1100	Double End Tamper. Price, each	**.75**

Attachments for Making 4-Inch Blocks on the Improved X-L-ALL Cement Block Machine, Size 8x12x16 Inches

We can furnish a double face plate and set of special end doors and attachments for making hollow blocks 4 inches high, 12 inches wide (in the wall) and 16 inches long on the Improved X-L-ALL Cement Block Machine. This outfit consists of a double face plate with a groove running through the center lengthwise, in which the special inside pallet rests. This face plate is made with two different designs. One plate has rock face on the lower half and a plain face on the upper half of the plate. With this double face plate we furnish two special end doors, which are divided into two designs. One half of each door is rock face and the other half plain face to match the face plate. To make return corners or blocks with both ends of the same design as the face, use the two special doors furnished with the outfit, but for making regular wall blocks, which should be cored on both ends, we furnish you with four cast iron end attachments, which are placed in the end of the machine over the special end doors, thereby forming a groove or core on both ends of these 4-inch course blocks for laying up in the wall. There is also required a dividing pallet for dividing the two styles of faces. We furnish two of these blind or dividing pallets with each outfit. If you find you have use for many of these 4-inch course blocks, you would probably require twenty-five or more of these dividing pallets. The lower block is formed on the regular pallet furnished with the machine. We also furnish with the outfit a double face plate of the same design for making half and quarter blocks (4x12 inches and 4x4 inches). The regular outfit for plain and rock face consists of the following:

1 Double Face Plate for making two designs of 4-inch course blocks, 4x12x16 inches, with plain face and rock face combination.
1 Double Face Plate of the same design for making half and quarter blocks.
1 Special Right Hand End Door, half rock and half plain face.
1 Special Left Hand End Door, half rock and half plain face.
4 Cast Iron End Attachments for forming core end opening in blocks.
2 Special Cast Iron Dividing Pallets, 12x16 inches.

No. 63A590 Set of Attachments for making 4-inch course blocks with plain and rock face for the Improved X-L-ALL Cement Block Machine, size 8x12x16 inches. Weight, about 135 pounds. Price........ **$9.35**

No. 63A592 Set of Attachments for making 4-inch course blocks with panel and tool face for the Improved X-L-ALL Cement Block Machine, size 8x12x16 inches. Weight, about 135 pounds. Price........ **9.35**

No. 63A594 Special Cast Iron Dividing Pallets, 12x16 inches, for making 4-inch course blocks. Price, each........ **.35**

NOTE—4-inch course blocks make a most desirable style of rock to use on any building. Lay a course of 12-inch blocks, rock face design, and then lay a course of 4-inch blocks, either plain face or tool face, or reverse the style of the 4-inch and 12-inch blocks and lay up these courses alternating with 4-inch and 12-inch blocks and you have a handsome wall. Many of our customers buy these special dividing pallets in lots of 100 at a time. The number you will require depends on the number of machines and men you work.

Bay Window Attachments for the 8x12x16-Inch Size of the Improved X-L-ALL Cement Block Machine

We can furnish a special bay window attachment which consists of an adjustable face plate for making any angle ranging from 20 to 80 degrees. This attachment makes both inside and outside angles. It requires a different face plate and set of attachments for each design of face. We can furnish this bay window angle attachment in either plain face, rock face, panel face, tool face, cobblestone face or rock face with tooled marginal edge, as wanted.

The face plate used for this adjustable bay window attachment can also be used for making a three-quarter length block with the regular machine outfit. For instance, the rock face adjustable bay window attachment for the 8x12x16-inch size Improved X-L-ALL Cement Block Machine will make a regular building block 12 inches long with one core. Three-quarter blocks are very handy to use in the wall, one block of this size taking the place of two smaller fractional blocks.

No. 63A560 Adjustable Bay Window Angle Attachments for Improved X-L-ALL Cement Block Machine, size 8x12x16 inches. Be sure to specify style of face plate wanted. Price... **$4.50**

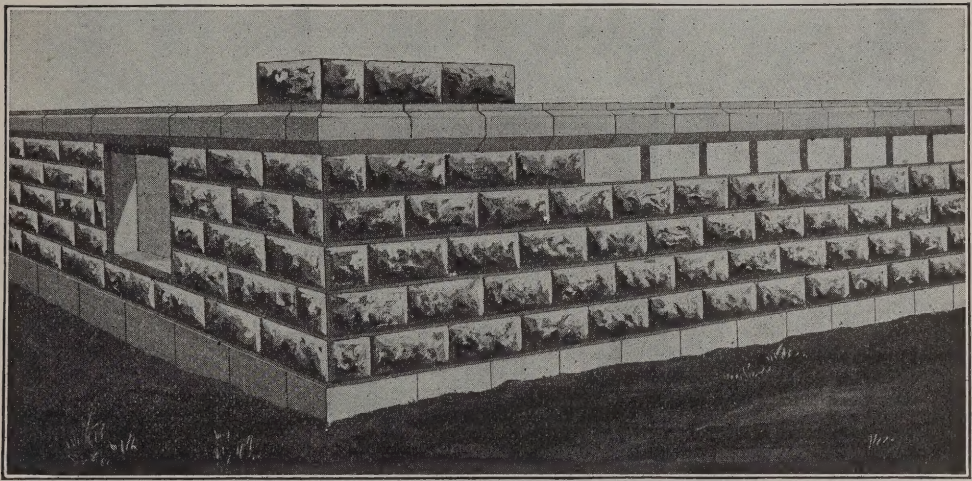
FINDS THE X-L-ALL FIRST CLASS IN EVERY RESPECT.

Willimansett, Mass., Dec. 6, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—I have been using one of your X-L-ALL Cement Block Machines purchased of you early in the season, for the last four months, and find it first class in every respect; in speed, ease of operation and the excellence of the blocks produced, being equal to or better than much higher priced machines that I have seen. Four men operating it have made thirty-five blocks per hour, and could easily average 300 per day. I enclose two photographs of a building (22½x71 feet) now under construction, for the Willimasett Cement Block Works. When completed will require another of your machines and a power mixer. Very truly, C. T. INGHAM.

Cement Blocks for Foundations



THE above illustration is from a photograph of a foundation built with 8x8x16-inch cement blocks. The builder of this job has used hollow blocks with a plain face for the foundation up to the grade line, from which point the wall is carried up with rock face hollow blocks of the same size. Note the upper right hand course of blocks directly under the water table. These blocks have been cored out on either end to receive the porch joists. This is done on either size of X-L-ALL or Buckeye Cement Block Machines by inserting in either end of the mould and next to the face plate, a block of wood, say an inch thick, 4 or 5 inches wide, and 8 inches long. This forms an opening on the face of the block, thereby enabling you to obtain the results shown above. The water table used in this foundation is made on the regular 8x8x16 size machine. We can furnish this water table face plate for any of our cement block machines. A complete outfit, consisting of a face plate for making whole blocks and another face plate for making halves and quarters, and generally but one end door is used, as the block is reversible, enabling you to make return corner blocks for laying up on either end or corner of the wall.

Every carpenter and contractor should own either an X-L-ALL or Buckeye Hollow Cement Block Machine, even if it were never used for anything other than making blocks for foundation work. Hollow cement building blocks are far superior either to brick or tile for foundation work and are in every way equal to natural stone and can be obtained for about one-quarter the expense of real stone. The price of stone differs very much in various localities and it is hard to find any basis for comparison. Even though you have a stone quarry on your land, it will cost you a good deal more to get out this rock, haul it to your building and lay it up in the wall than it will to purchase all of your material and hire your blocks made by day labor and lay them in the wall.

It might be interesting for you to know the cost of the foundation illustrated above. This foundation is 24x30 feet. There are five layers or courses of plain blocks and five layers of rock face blocks up to the water table. This makes a total of 760 blocks used in the construction of this basement or foundation up to the water table line. In other parts of this catalogue we have explained the proportion of material generally used in block making, and the average cost of material, etc., which brings the approximate cost of a good first class hollow cement block, 8x8x16 inches, up to about 10 cents each. 760 blocks on this basis would cost $76.00. There are 108 lineal feet of footing under the foundation, which cost 12½ cents per running foot, making the total cost of the foundation up to the line of the water table $89.50. Compare these figures with an estimate figured with natural stone or the best of brick, or for that matter, you cannot put in this foundation with common clay brick at $5.00 a thousand for anywhere near the price of cement blocks. Why not use hollow cement blocks for your foundations and thereby have them of the very highest grade of material obtainable and at much less than the cost of the cheapest brick?

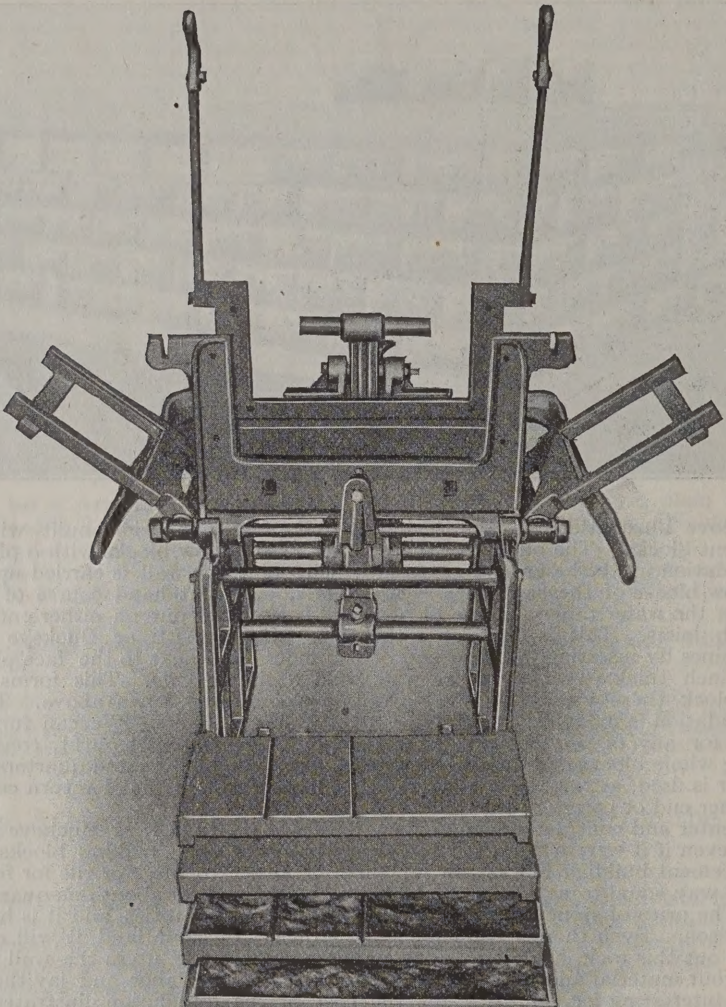
Warrenville, Ohio, Dec. 26, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I have received the X-L-ALL Cement Block Machine purchased from you some time ago and wish to say that I am more than pleased with it. It has proven entirely satisfactory.

Yours truly, WM. O. SERP.

The Improved X-L-ALL Combination Hollow Cement Block Machine

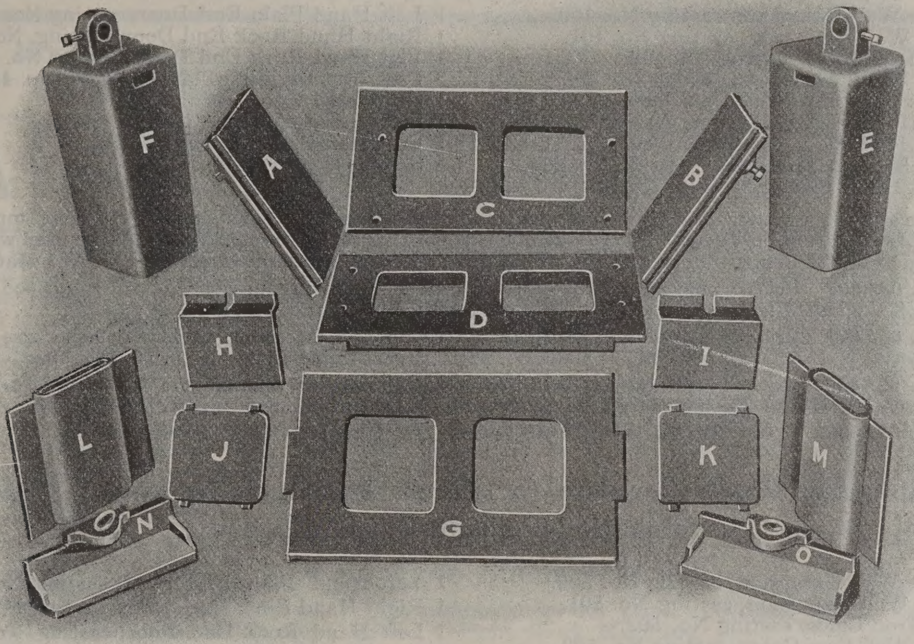


The above illustration shows the skeleton frame of the Improved X-L-ALL Cement Block Machine with regular outfit of face plates, namely:

1 Plain Face Plate, 8x8x16 inches, for whole blocks.
1 Plain Face Plate, for halves and quarters.
1 Rock Face Plate, 8x8x16 inches, for whole blocks.
1 Rock Face Plate, for halves and quarters.
1 Complete Base or Stand.
1 Skeleton Mould Box or Flask.

With the above outfit you can use either of the three sets of attachments described on the following pages, and have a complete machine to make blocks of the size these extra attachments are designed to make. If you are using one of our Improved X-L-ALL Combination Cement Block Machines, either size, you can purchase a set or two sets of extra attachments as specified on the following pages and you will then have a complete outfit for making the different sized blocks, all of which will have a face 8 inches by 16 inches. The face plates are the same for all machines, so that one set of face plates can be used on the three different combinations.

Parts of the Improved X-L-ALL Combination Hollow Cement Block Machine



A Left Hand End Door Plate.
B Right Hand End Door Plate.
C Rear or Back Wall Plate.
D Front Wall Plate.
E Right Hand Core.
F Left Hand Core.
G Cast Iron Pallet.
H Rear Wall Core Gate.
I Rear Wall Core Gate.
J Core Plug for pallet.
K Core Plug for pallet.
L Cast Iron Dividing Plate.
M Cast Iron Dividing Plate.
N Left Hand Joist Block Attachment.
O Right Hand Joist Block Attachment.

Box Mould or Flask, Complete, for the 8x8x16-Inch Improved X-L-ALL Combination Cement Block Machine

1 Back Wall Extension, casting No. 301.
1 Front Wall Extension, casting No. 300.
2 Cast Iron Cores, casting No. 302.
2 Rear Wall Core Gates, casting No. 303.
1 Right Hand Core End Door, casting No. 304.
1 Left Hand Core End Door, casting No. 305.
1 Right Hand Plain End Door, casting No. 310.
1 Left Hand Plain End Door, casting No. 311.
1 Right Hand Rock End Door, casting No. 316.
1 Left Hand Rock End Door, casting No. 317.
2 Cores for Pallets, casting No 308.
2 Joist Block Attachments, casting No. 309.
2 Cast Iron Dividing Plates, casting No. 353.
1 Graduated Bar, casting No. 169.
1 Steel Pallet, 8x8x16 inches.
1 Cast Iron Pallet, 8x8x16 inches.
1 Sample Wood Pallet.

The above set of attachments is interchangeable with the 8x10x16-inch or the 8x12x16-inch Improved X-L-ALL Combination Cement Block Machine Outfit. **This set of attachments cannot be used with the Standard X-L-ALL Cement Block Machine. They can be used only with the Improved X-L-ALL Machines.**

No. 63A397 Price of complete set of 8x8x16-inch Attachments for either size of Improved X-L-ALL Cement Block Machine, with only one cast iron, one steel and one sample wood pallet Price........ **$13.25**

No. 63A398 Price of complete 8x8x16-inch Attachments, interchangeable with either size of Improved X-L-ALL Cement Block Machine and with 25 cast iron pallets, size 8x8x16 inches. Price........ **18.75**

No. 63A399 Price of complete 8x8x16-inch Attachments, interchangeable with either size of Improved X-L-ALL Cement Block Machine and with 100 cast iron pallets, size 8x8x16 inches. Price........ **37 50**

No. 63A100 Cast Iron Pallets, 8x8x16 inches Weight, 7 pounds. Price, each........ **.25**

No. 63A200 Steel Pallets for 8x8x16-inch blocks. Price, each........ **.26**

Box Mould or Flask, Complete, for the 8x10x16-Inch Improved X-L-ALL Combination Cement Block Machine

1 Front Wall Extension, casting No. 400.
1 Rear Wall Extension, casting No. 401.
2 Cast Iron Cores, casting No. 402.
2 Rear Wall Core Gates, casting No. 403.
1 Right Hand Core End Door, casting No. 404.
1 Left Hand Core End Door, casting No. 405.
2 Cores for Pallets, casting No. 408.
2 Joist Block Attachments, casting No. 409.
1 Right Hand Plain End Door, casting No. 410.
1 Left Hand Plain End Door, casting No. 411.
1 Right Hand Rock End Door, casting No. 416.
1 Left Hand Rock End Door, casting No. 417.
2 Cast Iron Dividing Plates, casting No. 453.
1 Graduated Bar, casting No. 169.
1 Steel Pallet, 8x10x16 inches.
1 Cast Iron Pallet, 8x10x16 inches.
1 Sample Wood Pallet.

The above set of attachments is interchangeable with the 8x8x16-inch or 8x12x16-inch Improved X-L-ALL Combination Cement Block Machine Outfit. **This set of attachments cannot be used with the Standard X-L-ALL Cement Block Machine. They can be used only with the Improved X-L-ALL Machines.**

No. 63A497 Price of complete set of 8x10x16-inch Attachments for either size of Improved X-L-ALL Cement Block Machine, with only one cast iron and one sample wood pallet....... **$18.25**

No. 63A498 Price of complete 8x10x16-inch Attachments, interchangeable with either size of Improved X-L-ALL Cement Block Machine, with 25 cast iron pallets, size 8x10x16 inches.. **24.75**

No. 63A499 Price of complete 8x10x16-inch Attachments, interchangeable with either size of Improved X-L-ALL Cement Block Machine, with 100 cast iron pallets, size 8x10x16 inches.. **47.25**

No. 63A400 Cast Iron Pallets, 8x10x16 inches. Weight, 10 pounds. Price, each....... **.30**

Box Mould or Flask, Complete, for the 8x12x16-Inch Improved X-L-ALL Combination Cement Block Machine

1 Front Wall Extension, casting No. 500.
1 Rear Wall Extension, casting No. 501.
2 Cast Iron Cores, casting No. 502.
2 Rear Wall Core Gates, casting No. 503.
1 Right Hand Core End Door, casting No. 504.
1 Left Hand Core End Door, casting No. 505.
2 Cores for Pallets, casting No. 508.
2 Joist Block Attachments, casting No. 509.
1 Right Hand Plain End Door, casting No. 510.
1 Left Hand Plain End Door, casting No. 511.
1 Right Hand Rock End Door, casting No. 516.
1 Left Hand Rock End Door, casting No. 517.
2 Cast Iron Dividing Plates, casting No. 553.
1 Graduated Bar, casting No. 169.
1 Steel Pallet, 8x12x16 inches.
1 Cast Iron Pallet, 8x12x16 inches.
1 Sample Wood Pallet.

The above set of attachments is interchangeable with the 8x8x16-inch and 8x10x16-inch Improved Combination X-L-ALL Cement Block Machine Outfit. **This set of attachments cannot be used with the Standard X-L-ALL Cement Block Machine. They can be used only with the Improved X-L-ALL Machines.**

No. 63A597 Price of complete set of 8x12x16-inch Attachments for either size of Improved X-L-ALL Cement Block Machine, with only one cast iron pallet and one sample wood pallet.. **$22.50**

No. 63A598 Price of complete 8x12x16-inch Attachments, interchangeable with either size of Improved X-L-ALL Cement Block Machine, with 25 cast iron pallets, size 8x12x16 inches.. **29.75**

No. 63A599 Price of complete 8x12x16-inch Attachments, interchangeable with either size of Improved X-L-ALL Cement Block Machine, with 100 cast iron pallets, size 8x12x16 inches.. **55.75**

No. 63A500 Cast Iron Pallets, 8x12x16 inches. Weight, 12 pounds. Price, each..... **.35**

DECLARES THE X-L-ALL CEMENT BLOCK MACHINE A SUCCESS

Granite Falls, N. Car., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In regard to the X-L-ALL Cement Block Machine, to say the least, it is a success. I am taking advantage of all this good weather making some very fine blocks. Quite a lot of them, and they are good. My work has several other parties interested in them. I can't build until spring opens now, but will let you hear from me then. My blocks attract the attention of many visitors.

Respectfully, G. E. FLOWERS, M. D.

THE X-L-ALL CEMENT BLOCK MACHINE DOES AS GOOD WORK AS ANY HIGH PRICED MACHINE

Oxford, Ohio, Dec. 24, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In regard to your recent letter about my X-L-ALL Cement Block Machine, will say it is very satisfactory in every way and will do as good work as any of the high priced machines, and just as fast. Two men can make 100 blocks in ten hours with the X-L-ALL Cement Block Machine.

Yours truly, WM. E. HARDY.

OUR BANNER OUTFIT

The Most Complete and Up to Date Outfit for Manufacturing Hollow Concrete Building Blocks ever Offered to the Building Public

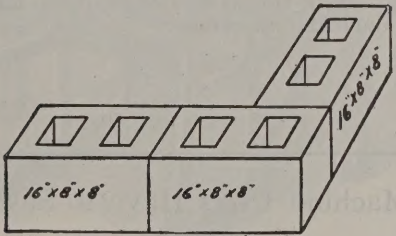
ANYONE wanting a complete outfit should purchase our Improved X-L-ALL Combination Cement Block Machine and Concrete Mixer, complete, for making blocks in three sizes, namely: 8x8x16 inches, 8x10x16 inches and 8x12x16 inches. Three of the most popular sized blocks ever manufactured on any single machine or on any lot of machines manufactured or sold by any concern in the world.

No. 63A600 The Banner Combination Outfit, consisting of one Improved X-L-ALL Hollow Concrete Block Machine, with three complete sets of attachments for making 8x8x16-inch, 8x10x16-inch and 8x12x16-inch hollow concrete building blocks, with choice of any two designs of face plates for making whole blocks, half and quarter blocks, and 25 cast iron pallets for each size of attachments, namely: 8x8x16 inches, 8x10x16 inches and 8x12x16 inches, and our No. 2 Improved X-L-ALL Concrete Mixing Machine, fitted with two cranks.
Price, complete **$143.50**

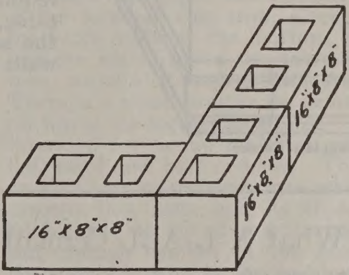
No. 63A1000 The Banner Combination Outfit, consisting of one Improved X-L-ALL Hollow Concrete Block Machine, with three complete sets of attachments for making 8x8x16-inch, 8x10x16-inch and 8x12x16-inch hollow concrete building blocks, with choice of any two designs of face plates for making whole blocks, half and quarter blocks, and 100 cast iron pallets for each size of attachments, namely: 8x8x16 inches, 8x10x16 inches and 8x12x16 inches, and our No. 2 Improved X-L-ALL Concrete Mixing Machine, fitted with two cranks. Price, complete **$211.00**

How to Lay up Corners with 8x8x16-Inch, 8x10x16-Inch and 8x12x16-Inch Hollow Concrete Building Blocks.

These instructions will help you. This system works out perfectly with either the Improved X-L-ALL or the Improved Buckeye Hollow Cement Block Machines.

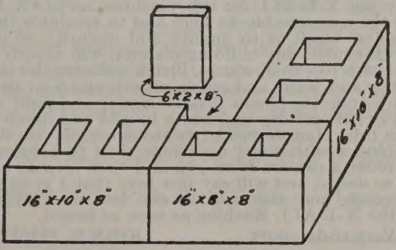


First Course, 8-inch Wall

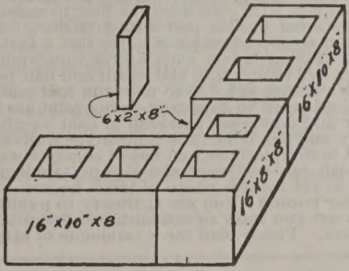


Second Course, 8-inch Wall

The above illustrations show the method of returning corners with regular blocks, 8x8x16 inches. The left hand illustration represents a corner of the first course, while the right hand illustration represents the same corner as laid with the second course of blocks.



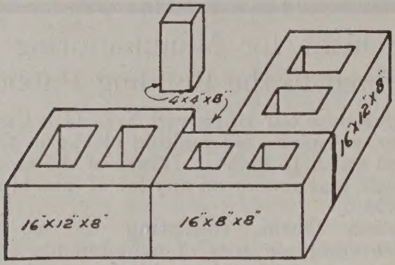
First Course, 10-inch Wall



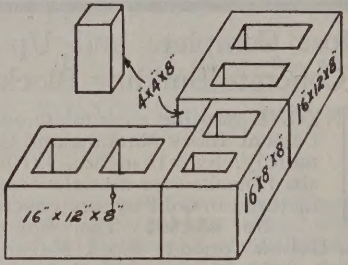
Second Course, 10-inch Wall

The left hand illustration shows the method of laying up a return or outside corner of a wall made of 8x10x16-inch blocks. Use an 8x8x16-inch block for the corner and make a filler on your machine by blocking up in one end of the mould box so as to produce a block 6x2x8 inches to put in the inside corner. This plan for the first course. The illustration to the right shows the method of laying the return or outside corner with the second layer of blocks. Reverse the position of the 8x8x16-inch block and use the filler as indicated. This system enables you to lay and turn a complete corner and have every mortar joint in line and showing an 8x16-inch face.

How to Lay up Corners with 8x8x16-Inch, 8x10x16-Inch and 8x12x16-Inch Hollow Cement Building Blocks—Continued

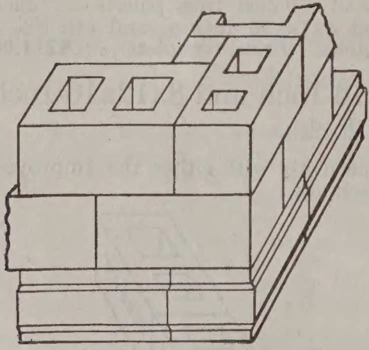


First Course, 12-inch Wall



Second Course, 12-inch Wall

The illustrations above show the method of laying the first and second courses of blocks around an outside corner of a wall made of hollow concrete blocks, 8x12x16 inches. You will note that we use an 8x8x16-inch block for the corner, the same as in the 10-inch wall shown on preceding page, and reverse the position of the 8-inch block with each course. With the 12-inch wall we use a filler, 4x4x8 inches. This makes a perfect return corner.



Complete Corner

The illustration to the left shows a complete corner laid up with water table and regular course of blocks, 8x12x16 inches. This method of laying up a wall gives you a perfect bonding surface, enables you to build a wall of almost any thickness and have the outside corner rows of mortar joints appear absolutely in line with one another. You will appreciate this system of laying up a corner when used on a large building, requiring 12-inch blocks for the foundation up to the water table, 10-inch blocks for the first story and 8-inch blocks for the second story. With this system of laying up a corner the walls present an unbroken appearance.

What X-L-ALL Cement Block Machine Users Have to Say

POSEY COMPANY, Contractors and Builders,
Cor. Tennessee and Kelly Sts. (on M. J. & K. C. R. R.)

Mobile, Ala., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—In answer to yours of recent date as to my opinion of the X-L-ALL Cement Block Machine bought of you some time ago, will say that I have found your block machine, like everything else I have bought of you, as good as any and the price one-half to one-third that of other dealers. Associated with two men from Grand Rapids, Mich., we were the first to manufacture concrete building blocks in this city. We used a machine made in Grand Rapids that cost $100.00. I would not give my X-L-ALL for this machine, as the X-L-ALL is faster and requires less labor. We had a task to introduce the concrete blocks here and to establish the importance of placing orders with a firm who would make an honest block as to quality and quantity of materials. I make a five to one base and a half and half petrified face. Of course, any building material will absorb moisture more or less, but the five to one and half and half blocks absorb less than others. Brick walls require skilled and high priced labor to construct, being solid are likewise weighty and settle and crack, absorb and hold heat in hot weather and dampness and chill in cold weather. The hollow concrete blocks make a strong and light wall with ordinary and less labor; the vents in the walls keep them cool in hot and dry and warm in cold and damp weather. I would prefer plastering on naked concrete walls rather than brick, but do not advocate either, but do think that metal lath can be better and cheaper applied to concrete blocks with wood insertions than to brick walls. I cannot as yet furnish photo of block houses, but will again order a camera from you and then be able to comply with your request. You are at liberty to publish this if you so desire, and will say just here that I greatly admire the interest you show to establish low prices and give good goods and fair and honest treatment to all your customers. Please mail me a catalogue of attachments for the X-L-ALL Machine as soon as issued.

Very truly yours, JOHN R. POSEY.

THINKS HIS MACHINE O. K. IN EVERY RESPECT.

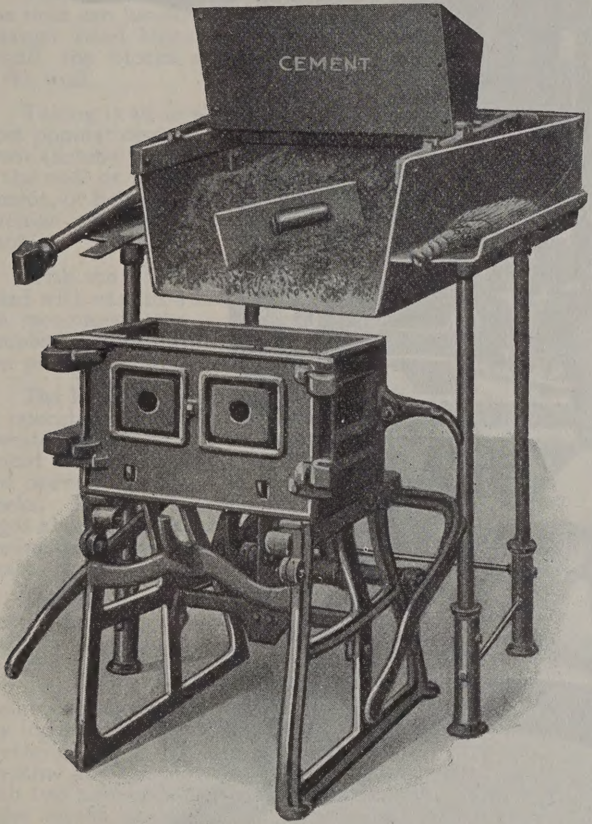
Alma, Nebr., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I am using one of your X-L-ALL Cement Block Machines, size 8x8x16 inches, and I think that my machine is O. K. in every respect. The blocks so far as I can see are just as good as any I ever saw or had anything to do with. I do not think the walls will get damp by plastering directly on the blocks as the holes in the blocks are large enough to serve as a dead air space. The machine is all right. Please send me one of your special catalogues of cement block machinery, and oblige, Yours truly,

M. F. ROBISON.

Our All Steel X-L-ALL Feed Table or Hopper For Cement Block Machines



WE recommend the use of a feed table or hopper placed over the top of your cement block machine. Many of our customers build a table of this kind out of wood, using common rough boards and it answers the purpose admirably; in fact, is just as handy and saves you just as much work as though it were made out of steel or hardwood. To meet the demands of our customers who have made inquiry for a feed table, stating that they would rather buy one than go to the expense and trouble of making one, we have had a feed table built entirely out of steel and iron. The hopper or tray of this feed table is made out of heavy sheet steel, the sides and end and top of which are reinforced with heavy strap or bar iron so as to make it solid. The legs of the table are made of ¾-inch standard iron pipe; the bottom or feet of the legs are cast iron, strengthened by brace rods at the bottom, and the legs are attached to the table by cast iron sockets threaded for the pipe. There is a small hopper or cement box on top of the regular feed table This is intended for facing material, generally half sand and half cement. There are two sockets or bearings into which this cement box rests, and its object is to enable you to tilt it over forward and put enough cement in the bottom of the mould box for facing the block, then fill up the rest of the block from the mixture in the regular hopper or feed table. There are two wings or flanges on either side of the feed table, making a handy place to lay your trowel and whisk broom or brush, two articles that should always be used around a cement block machine to brush away the surplus concrete, etc., from face plates, end doors and other parts of the machine. This also is a very handy place to lay the tamper and strippers when not in use. This is a very substantial table It is well built and will pay for itself in a few days' time. You should by all means have a table or hopper over your machine. If you do not make one yourself, you should buy this one We ship this feed table knocked down and crated to insure safe delivery and secure a low rate of freight Weight, about 100 pounds. This all steel feed table is shipped with our X-L-ALL line of cement block machinery from Bradley, Illinois

No 63A999 X-L-ALL Feed Table or Hopper, with cement box as shown in illustration
Price **$7.50**

No. 63A998 X-L-ALL Feed Table or Hopper, without cement box. Price **5.50**

MAKES A THIRD MORE BLOCKS THAN CAN BE MADE ON ANOTHER STYLE MACHINE.

Yuma, Colo., Dec. 1, 1906.

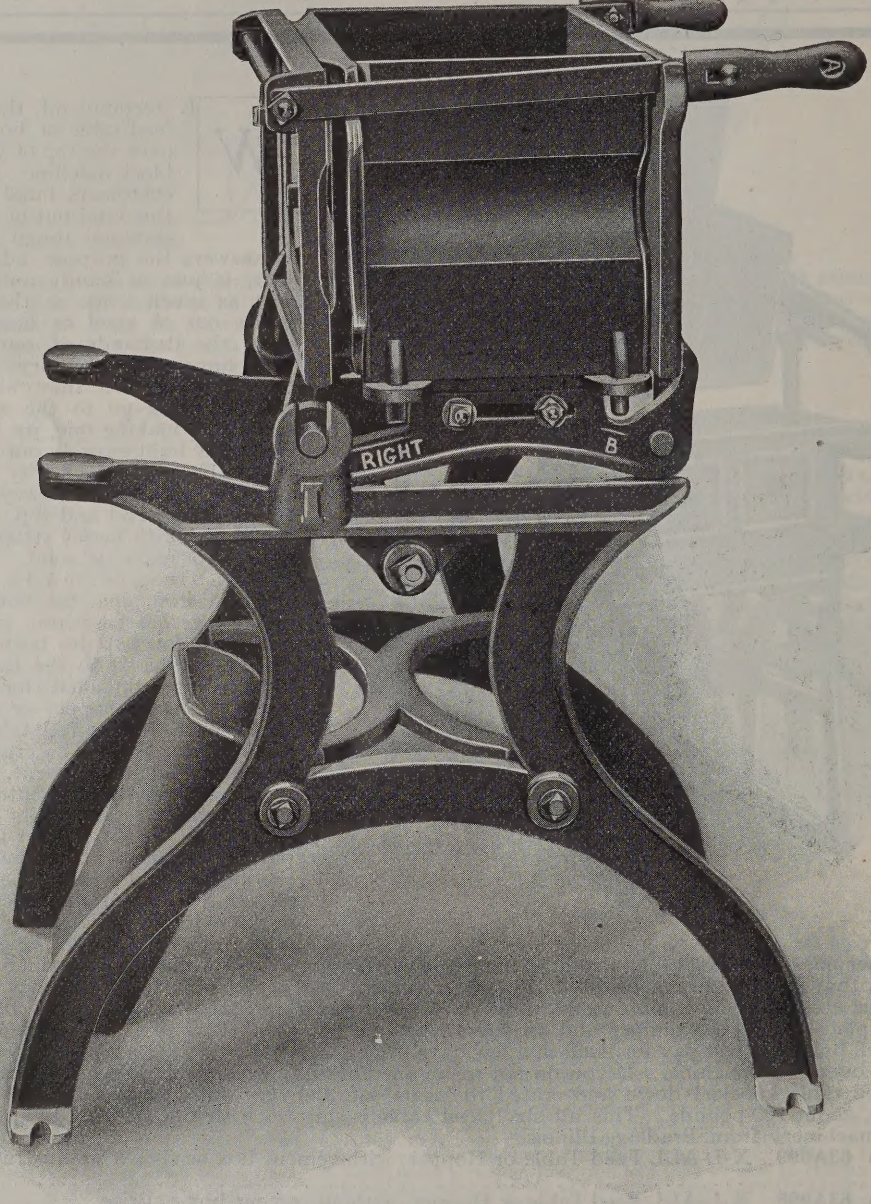
Sears, Roebuck & Co. Chicago, Ill.

Dear Sirs:—The X-L-ALL Cement Block Machine which I purchased from you gives entire satisfaction. I am well pleased with it and can make a third more blocks in a day on it than on a lift-up machine and can make a more perfect block, as I never break them in removing them from the machine

Yours very truly, W. S KIRK.

The Buckeye Cement Block Machine

Size 8x8x16 Inches



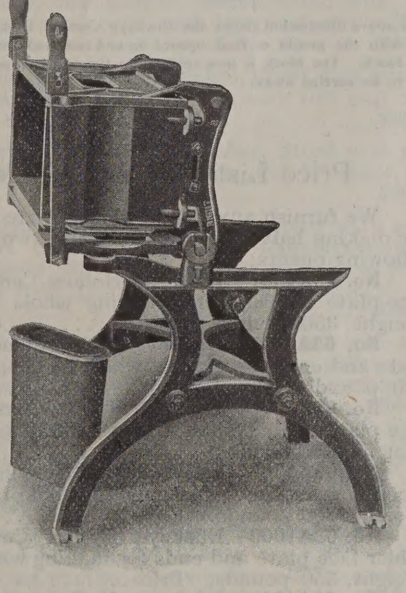
THE Buckeye Hollow Cement Building Block Machine is a good, practical machine for the use of any person manufacturing cement blocks, for either his own use or to sell. The machine is low enough in price so that every contractor and builder can afford to own one. The machine will pay for itself in making the foundation blocks for the first small job of work you have. It makes a block in actual measurement 7¾ inches high, 8 inches thick (in the wall) and 15¾ inches long, which lays up in the wall 8x8x16 inches. This allows space for the necessary amount of mortar. A 16-inch block is by far the most satisfactory because of the fact that floor joists, studding, etc., are generally spaced 16 inches from center to center. The Buckeye Hollow Cement Block Machine makes a block that is well proportioned. There is but one core to these blocks and the core is placed in position and withdrawn by hand, this being but a small matter and requiring but a very little time. It insures the core being removed without any danger of the block cracking. The core is of proportionate size to enable you to make a block the proper size to stand a severe testing strain and at the same time does not use more material than is absolutely necessary to produce a first class block. The core is of the proper size and shape to make the opening in the center of the block as large as possible and yet give the necessary strength where strength is required to stand the strain and weight of the walls. The large sized core used on these hollow blocks creates a large air chamber in the walls, thus reducing to a minimum the possibility of dampness entering the walls.

This machine not only makes a good strong block, but a size that is very convenient to handle. One man can handle an 8x8x16-inch block and lay it up in the wall easily and speedily. Where a larger sized block is used it adds expense to the job of work in that it requires two men to handle the blocks, and in some of the large sizes a derrick is necessary to lay the blocks in the wall.

Taking it all in all, the Buckeye Hollow Cement Block Machine has every feature found in the most popular cement block machine. Like all our cement block machines, it makes the block face down, thereby permitting richer material to be used for facing. This not only adds to the appearance of the wall or structure when completed, but by using a facing of two parts sand to one part cement, or half and half, makes a block with a face impervious to moisture. By using a face down machine you are enabled to secure blocks of a quality which is not possible with a side face machine.

With the Buckeye Hollow Cement Block Machine we use iron pallets. The iron pallets are provided with cast iron handles or end holes, making them very handy for carrying away the blocks. We recommend the use of iron pallets, and while they are, perhaps, a little more expensive when completing your outfit, they are at all times, we believe, more satisfactory than wood. These cast iron pallets are well made and they, with ordinary care, will last a good many years.

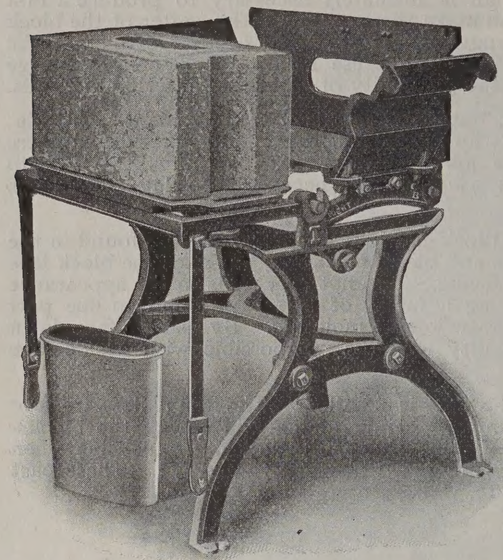
The Buckeye Hollow Cement Block Machine can be operated by one man if necessary, although to operate the machine to its utmost capacity, three men should be used, one to mix the material, one to tamp and operate the machine and one to carry away the blocks. Note the testimonials appearing in these pages about the capacity of the machine under various circumstances and how well the Buckeye Machine pleases the purchaser.



Above illustration shows the Buckeye Cement Block Machine with a mould or flask tilted over toward you, in which position the core drops from the machine. You then unlatch the levers, push the back wall and end doors away from the block as shown on the following page.

The Buckeye Hollow Cement Block Machine will make just as good blocks as can be made on any machine, regardless of price. It is very rapid. The machine has no gears, cogs or complicated parts to clog up and get out of order. The construction of the Buckeye Hollow Cement Block Machine is such that any ingenious man can fix up an attachment to make anything for a building. For instance, with this machine you can make standard hollow cement blocks with two core ends for laying up in the wall. You can make return or outside corner blocks, inside corner blocks, gable blocks, porch piers or square column blocks, chimney blocks, plain foundation blocks, joist blocks, door and window frame blocks, solid blocks, half blocks, quarter blocks. All of these different blocks are made on the regular outfit which we furnish with the machine, complete, for $21.25. With the machine we furnish two cast iron attachments to put on either end of the machine in connection with the core end doors for making joist blocks. These attachments form an opening in the end of the blocks to allow you to set 2-inch joists in the wall, thus doing away with the necessity of joist hangers. With your saw and hammer you can easily form a box mould to put in one end of the machine to make an opening in the end of the block for window frame. We find there is such a variation in the sizes and kind of window frames that we do not attempt to furnish cast iron attachments for this purpose, but it is an easy matter to make a wood mould so as to form an opening in the end of the block the exact size and shape wanted for your window frame, either for sash weights or plain windows. To make chimney blocks, make a wood box or core, 4½x8 inches, fill and tamp the machine up to within 4½ inches from the top, then put in this box or core in the center of the mould box, tamping it 4 inches at each end, and remove the block, then the box or core, and you have a chimney block or a block for porch piers, etc. You can also use a round core in the center of the machine for making a round opening for chimney blocks instead of square. All of these little features are possible on the Buckeye Machine at very little expense.

These blocks can be made by you with the regular outfit instead of having to buy special faces, end doors, etc., as is the case with almost every other machine now on the market. The Buckeye Cement Block Machine is designed with a view of meeting the requirements of the general trade and at a moderate price.



The above illustration shows the Buckeye Cement Block Machine with the mould or flask opened up and removed from the new block. The block is now resting on the cast iron pallets ready to be carried away.

If you own a sand bank or a gravel pit why not turn it into money? Why allow it to be hauled away by railroad companies and commissioners of public highways at a few cents a load, when by an investment of less than $25.00 you can net a handsome profit for yourself from this sand or gravel? Remember that four-fifths of the material used in making the hollow cement building block is sand and gravel. Therefore, four-fifths of the material you would use for constructing your buildings will come right out of your own premises. The blocks may be made at odd times when you have nothing to do, and it does not require a stone or brick mason to lay up these building blocks.

With the Buckeye Hollow Cement Block Machine, size 8x8x16 inches, we furnish the following:

1 Face Plate for making whole blocks.
1 Face Plate of the same design for making half and quarter blocks.
2 Core Ends.
1 Core Gate for front wall.
1 Core Gate for pallets for chimney solid and fractional blocks.
1 End to match the face for return corners.
1 End to match the face for porch piers.
1 Core Gate for rear wall.
1 Dividing Plate for making half blocks.
1 Dividing Plate for making quarter blocks.
1 Left Hand Joist Block Attachment.
1 Right Hand Joist Block Attachment.
1 Striker.
1 Double End Tamper.
1 Standard Core.
25 Cast Iron Pallets.

Weight of complete outfit as described above, 350 pounds.

Price List Buckeye Cement Block Machine, Size 8x8x16 Inches

We furnish any design of face plate specified by you. With this face plate we furnish plate for making halves and quarters and two end doors to match. You may order the choice of the following outfits:

No. 63A1001 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 350 pounds. Price.......... **$21.25**

No. 63A1003 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets Weight, 350 pounds. Price.......... **$21.25**

No. 63A1005 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 350 pounds. Price.......... **$21.25**

No. 63A1007 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 350 pounds. Price.......... **$21.25**

No. 63A1009 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 350 pounds. Price.......... **$21.25**

No. 63A1011 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 350 pounds. Price.......... **$21.25**

No. 63A1013 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 375 pounds. Price.......... **$25.75**

No. 63A1015 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight of complete outfit, 375 pounds. Price..... **$25.75**

No. 63A1017 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight of complete outfit, 375 pounds. Price..... **$25.75**

Price List Buckeye Cement Block Machine—Continued

No. 63A1019 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight of complete outfit, 375 pounds. Price. . **$25.75**

No. 63A1021 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight of complete outfit, 375 pounds. Price.......... **$25.75**

No. 63A1023 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight of complete outfit, 375 pounds. Price.......... **$25.75**

No. 63A1025 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$40.00**

No. 63A1027 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$40.00**

No. 63A1029 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price **$40.00**

No. 63A1031 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$40.00**

No. 63A1033 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$40.00**

No. 63A1035 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$40.00**

No. 63A1037 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 100 cast iron pallets, also a complete set of bay window adjustable angle plate and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight, about 1,000 pounds. Price.......... **$44.50**

No. 63A1039 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight, about 1,000 pounds. Price **$44.50**

No. 63A1041 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight, about 1,000 pounds. Price...... **$44.50**

No. 63A1043 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight, about 1,000 pounds. Price **$44.50**

No. 63A1045 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight, about 1,000 pounds. Price **$44.50**

No. 63A1047 Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight, about 1,000 pounds. Price.......... **$44.50**

At the above prices we deliver our Buckeye Cement Block Machines and extra parts, as shown on this and preceding page, carefully packed for shipment, on board cars at our factory in Central Ohio, from which point the purchaser pays the freight.

Price List of Attachments for the Buckeye Cement Block Machine, Size 8x8x16 Inches

No. 63A1101	Plain Face Plates to make whole blocks. Price, each	**$1.50**
No. 63A1102	Plain Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1176	Plain End Doors, right or left hand. Price, each	**.95**
No. 63A1105	Medium Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1106	Medium Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1107	Rock Face Plates for making ¾ blocks and ⅛ blocks. Price, each	**1.50**
No. 63A1178	Medium Rock End Doors, right or left hand. Price, each	**.95**
No. 63A1111	Heavy Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1112	Heavy Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1114	Shallow Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1115	Shallow Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1118	Tool Edge Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1119	Tool Edge Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1180	Tool Edge Rock Face End Doors, right or left hand. Price, each	**.95**
No. 63A1122	Panel Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1123	Panel Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1182	Panel Face End Doors, right or left hand. Price, each	**.95**
No. 63A1125	Tool Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1126	Tool Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1184	Tool End Doors, right or left hand. Price, each	**.95**
No. 63A1128	Cobblestone Face Plates for whole blocks. Price, each	**1.50**
No. 63A1129	Cobblestone Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1186	Cobblestone End Doors, right or left hand. Price, each	**.95**
No. 63A1132	Water Table Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1133	Water Table Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1188	Water Table End Doors, right or left hand. Price, each	**.95**
No. 63A1137	Face Plates for making imitation pressed brick, whole blocks. Price, each.	**1.50**
No. 63A1138	Face Plates for making imitation pressed brick, halves and quarters. Price, each	**1.50**
No. 63A1190	End Door for making imitation pressed brick design, right or left hand. Price, each	**.95**
No. 63A1140	Ornamental Design Face Plate with whirlwind scroll, for making whole blocks. Price, each	**1.50**
No. 63A1141	Ornamental Design Face Plate with whirlwind scroll, for making half and quarter blocks. Price, each	**1.50**
No. 63A1192	Ornamental Design End Doors with whirlwind scroll, right or left hand. Price, each	**.95**
No. 63A1144	Ornamental Face Plate with rope design on face for making whole blocks. Price, each	**1.50**
No. 63A1145	Ornamental Face Plate with rope design on face for making half and quarter blocks. Price, each	**1.50**
No. 63A1194	Ornamental End Door with rope design, right or left hand. Price, each	**.95**
No. 63A1151	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each	**1.50**
No. 63A1152	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each	**1.50**
No. 63A1153	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each	**1.50**
No. 63A1154	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each	**1.50**
No. 63A1155	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each	**1.50**

NOTE—To make halves and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a whole block, produces very desirable results.

No. 63A1196	End Doors, right or left hand. Broken Ashler Design. Price, each	**.95**
No. 63A1500	Pallets for regular blocks. Weight, about 8 pounds each. Price, each	**.25**
No. 63A1100	Double End Tamper. Price, each	**.80**

Bay Window Attachments for Buckeye Hollow Cement Block Machines, Size 8x8x16 Inches

We can furnish our adjustable bay window angle plate and attachments, which consist of a face plate with an adjustable angle attachment fitted to one end and two special end doors for making any degree of angle blocks, in the following designs of face plates at the prices named:

No. 63A1301	Set of Complete Bay Window Attachments, Plain Face Design. Price	**$4.50**
No. 63A1302	Set of Complete Bay Window Attachments, Rock Face Design. Price	**4.50**
No. 63A1303	Set of Complete Bay Window Attachments, Panel Face Design. Price	**4.50**
No. 63A1304	Set of Complete Bay Window Attachments, Cobblestone Face Design. Price	**4.50**
No. 63A1305	Set of Complete Bay Window Attachments, Tool Face Design. Price	**4.50**

Attachments for Making Radius Blocks on the Buckeye Hollow Cement Block Machines, Size 8x8x16 Inches

We can furnish a radius or circle face plate in a number of different designs for making circle blocks. With this face plate are furnished two special end doors to complete the set of attachments. We can furnish these circle plates to make either an 8-foot, 10-foot or 12-foot circle for bay windows, etc. It requires a different set of attachments to make the different angles. We can furnish these circle plate attachments in the following designs and at the prices printed below:

No. 63A1351 Set of Complete Attachments for making 8-foot radius blocks. Plain Face Design. Price, complete.......... $4.50

No. 63A1353 Set of Complete Attachments for making 10-foot radius blocks. Plain Face Design. Price, complete.......... 4.50

No. 63A1355 Set of Complete Attachments for making 12-foot radius] blocks. Plain Face Design. Price, complete.......... 4.50

No. 63A1357 Set of Complete Attachments for making 8-foot radius blocks. Rock Face Design. Price, complete.......... 4.50

No. 63A1359 Set of Complete Attachments for making 10-foot radius blocks. Rock Face Design. Price, complete.......... 4.50

No. 63A1361 Set of Complete Attachments for making 12-foot radius blocks. Rock Face Design. Price, complete.......... 4.50

Price List of Attachments and Extras for Making 4-inch Course Blocks on the Buckeye Hollow Cement Block Machine, Size 8x8x16 Inches

We can furnish special face plates for the Buckeye Hollow Cement Block Machine for making 4-inch course blocks (4x8x16 inches), in either plain face, rock face, panel face or tool face design. It requires two sets of special end doors and two face plates to make a complete outfit for making 4-inch blocks. You will need one face plate for making whole blocks, 4x8x16 inches, and you should have another face plate of the same design for making halves and quarters, also one pair of core end doors and another pair of end doors to match the face plate. You will require half and quarter blocks, and money spent for a face plate to make fractional blocks is well invested and will enable you to produce the very best results.

No. 63A1201 Plain Face Plates for making 4-inch course blocks, size 4x8x16 inches. Makes two 4-inch blocks at a time. Price, each.......... $1.50

No. 63A1202 Plain Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... 1.50

No. 63A1203 Rock Face Plates for making 4-inch course blocks, size 4x8x16 inches. Makes two 4-inch blocks at a time. Price, each.......... 1.50

No. 63A1204 Rock Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... 1.50

No. 63A1205 Panel Face Plates for making 4-inch course blocks, size 4x8x16 inches. Makes two 4-inch blocks at a time. Price, each.......... 1.50

No. 63A1206 Panel Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... 1.50

No. 63A1207 Tool Face Plates for making 4-inch course blocks, size 4x8x16 inches. Makes two 4-inch blocks at a time. Price, each.......... 1.50

No. 63A1208 Tool Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... 1.50

No. 63A1251 End Doors, Plain Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair.......... .95

No. 63A1252 End Doors, Rock Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair.......... .95

No. 63A1253 End Doors, Panel Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair.......... .95

No. 63A1254 End Doors, Tool Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair.......... .95

No. 63A1255 Core End Doors (make the cove end on regular blocks), for making 4-inch course blocks. You will need one pair of this style of end doors with any 4-inch outfit. Right and left hand, complete. Price, per pair.......... .95

No. 63A1256 Special Inside Core Pallets, 8x8x16 inches, used when making two 4-inch course blocks at one time. Cast iron. These inside or divisional pallets should be used where you have any large number of 4-inch course blocks to make. With the use of these dividing pallets you can work your machine to its greatest capacity. Price, each.......... .25

A BUCKEYE MACHINE PAYS FOR ITSELF.

1814 N. Rural St., Indianapolis, Ind., Dec. 1, 1906.

Sears, Roebuck & Co., Chicago, Ill.

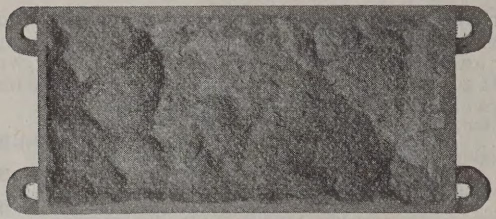
Gentlemen:—Your Buckeye Cement Block Machine is much more than is claimed for it, and it is superior to a $135.00 machine of another make which I saw not long ago. I would heartily recommend it to all contractors and builders, as it will pay for itself in the first two or three foundations.

If you have any one in this community who would like to see the machine, I will be glad to have you refer them to me, for I know they will buy one as soon as they see how convenient it is.

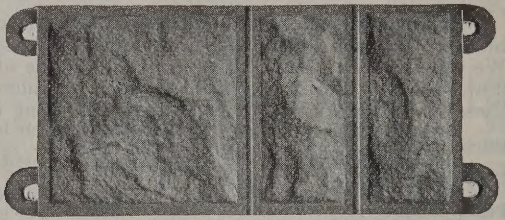
I would like to have your new Catalogue of Millwork and your Big General Catalogue. Wishing you every success, I remain,

Yours truly,
E. W. CARROLL.

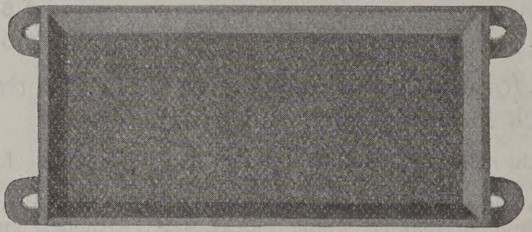
Face Plate and End Doors for Buckeye Cement Block Machines



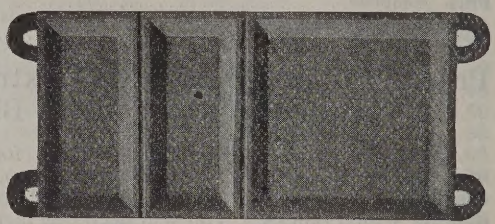
Rock Face Plate for making whole blocks, 8x16 inches on the face, with Buckeye Machine



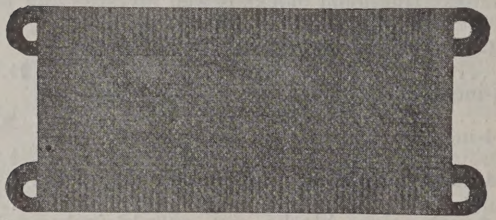
Rock Face Plate for making halves and quarters on the Buckeye Machine



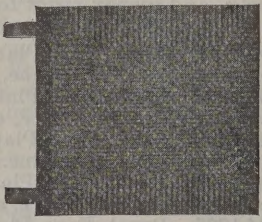
Panel Face Plate for making whole blocks, 8x16 inches on the face, with Buckeye Machine



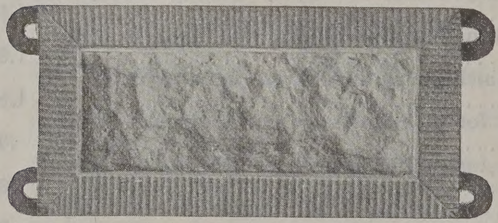
Panel Face Plate for making halves and quarters on the Buckeye Machine.



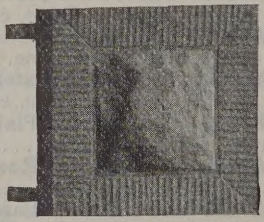
Tool Face Plate for making whole blocks, 8x16 inches on the face, with Buckeye Machine



End Door to match tool face plate. All end doors on the Buckeye Machine are interchangeable, either right or left hand



Marginal Tooled Rock Face Plate for making whole blocks, 8x16 inches on the face, with Buckeye Machine

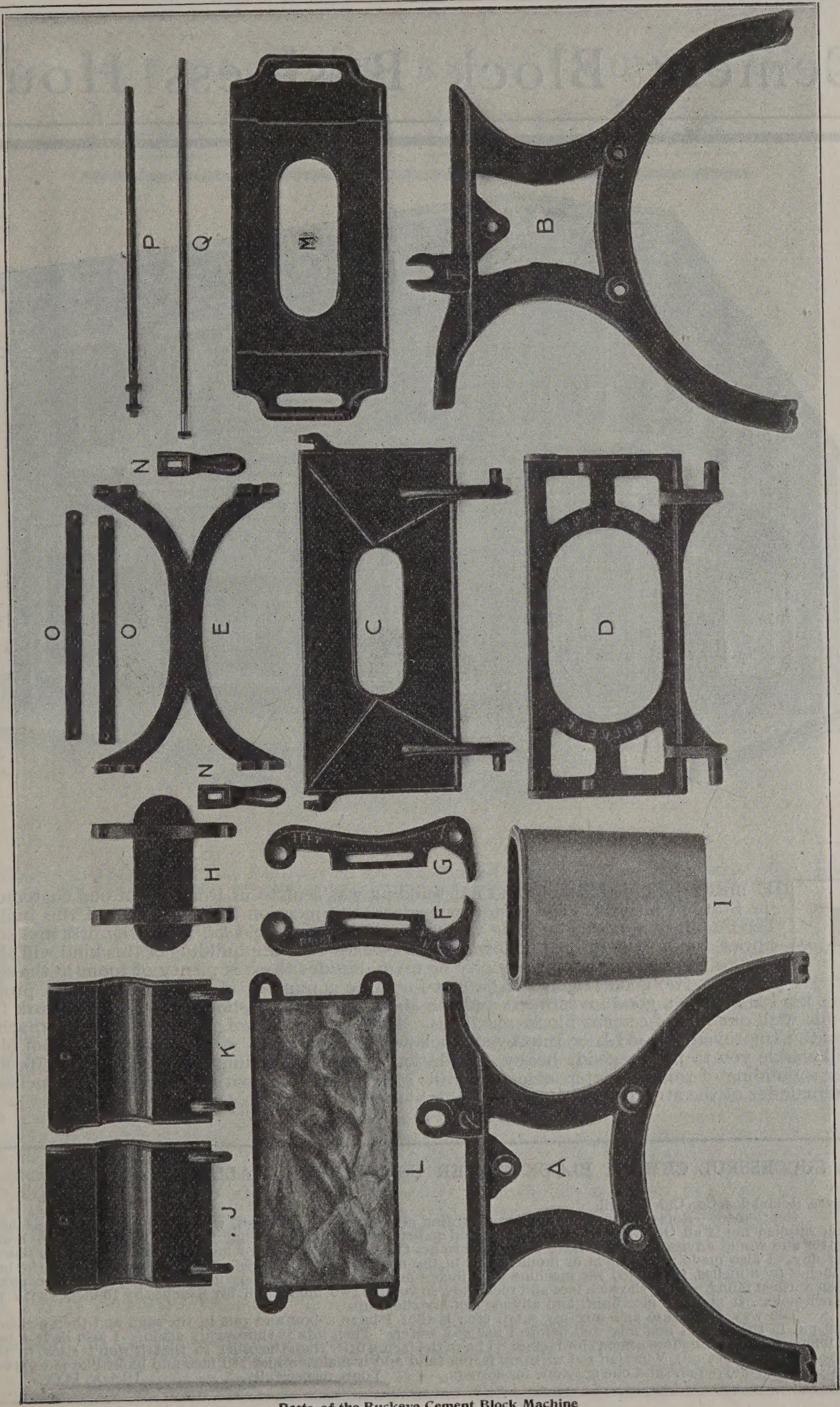


End Door to match marginal tooled rock face plate. All end doors on the Buckeye Machine are interchangeable, either right or left hand

How to Order Repairs for the Buckeye Cement Block Machines

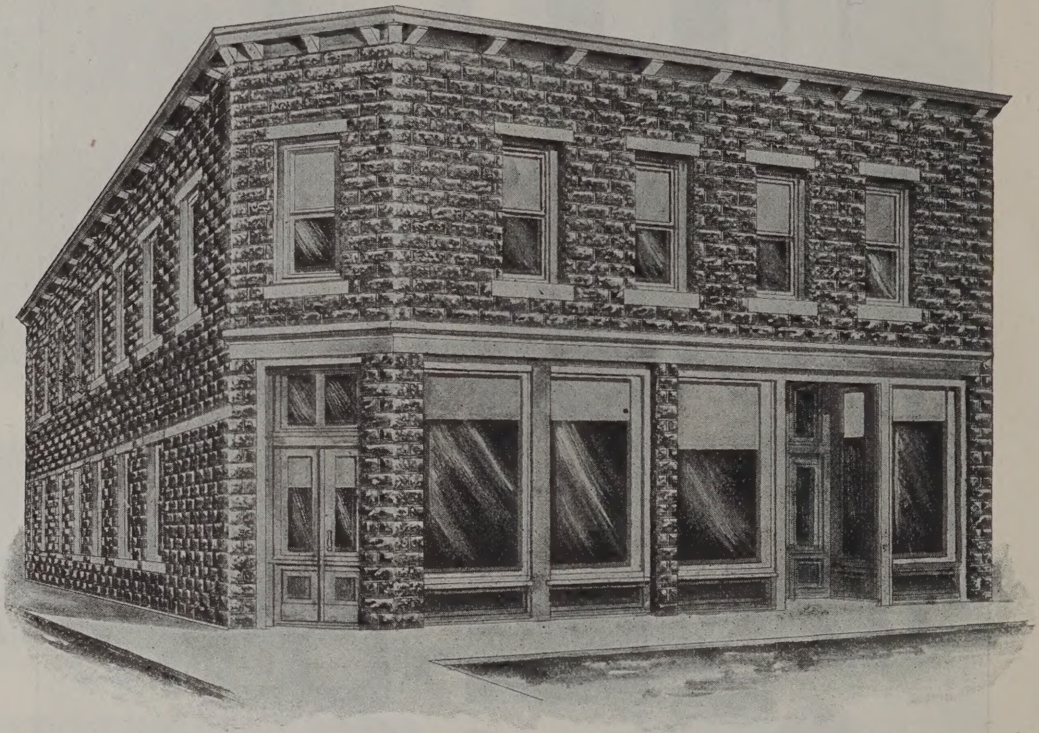
We reproduce on page 63 a photograph showing every part used in the construction of the Buckeye Cement Block Machine. Should you order repairs at any time, this chart will enable you to locate the correct name of the part wanted; then, in addition to this, be sure to give us the catalogue number, name and size of your machine. This will assist us in locating your original order, so that no mistake will be made in sending the parts to you.

	Price, each		Price, each
A is a Right Hand Base or Stand	$2.00	I is a Cast Iron Core	$1.10
B is a Left Hand Base or Stand	2.00	J is a Left Hand End Door	.95
C is the Rear Back Wall	2.00	K is a Right Hand End Door	.95
D is the Front Wall	2.00	L is a Face Plate, size 8x8x16 inches	1.50
E is the Cross Base for stand	.90	M is a Cast Iron Pallet, size 8x8x16 inches.	.25
F is the Right Hand Rocker Bed	.50	N is a Cast Handle for lock	.30
G is the Left Hand Rocker Bed	.50	O Steel Bar for lock	.25
H is a Core Gate for pallet	.50	P Lower Iron Rod for stand	.30
		Q Upper Iron Rod for stand	.30



Parts of the Buckeye Cement Block Machine

Cement Block Business House



THE illustration of this store and flat building was sent to us from one of our customers in the State of Kansas. The customer neglected to mention the exact cost of this building. The foundation of this building was made with 10-inch blocks, while the first and second stories are of 8x8x16-inch hollow cement blocks. A store building of this kind will always rent to good advantage in any city or town, besides there is plenty of room in the second story for two good large sized flats or for quite a number of offices. Business property of this kind is always a good investment and the above illustration shows the range of work found possible with our line of cement block machines. By buying one of our combination machines, either the Improved X-L-ALL or Improved Buckeye, both of which will make three sizes of blocks, it will enable you to put a good, heavy foundation under a building of blocks 8x12x16 inches under a building of this character, erect the walls of the first story with blocks 8x10x16 inches and the remainder of the structure with 8x8x16-inch blocks.

A SUCCESSFUL CEMENT BLOCK MAKER USING OUR X-L-ALL.

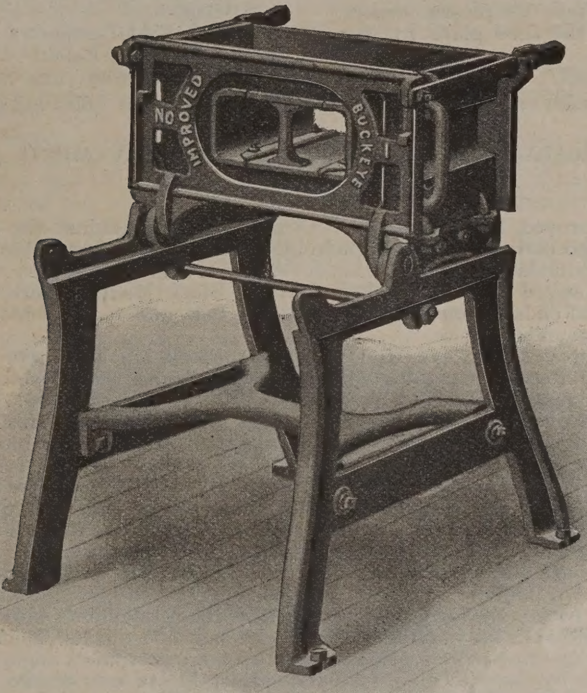
Casey, Ill., Dec. 2, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Replying to your inquiry regarding cement block machines, will say the X-L-ALL machine you shipped me is all O. K. I tried to make wood pallets for the machine, but find the iron pallets are much better and would advise anyone getting a machine to get the iron pallets. Two men can easily make 100 blocks per day. I also made a wood box or mould to fit in the machine and it makes a fine flue box. I made the box 4 inches by 8 inches, then filled the machine up 4 inches and placed my core box in position, tamped thoroughly then finished filling. I use the rock face and rock ends, so you see two blocks will lay 8 inches by 16 inches with an 8-inch hole. It makes a nice finish and anyone can lay them up.

The way I measure and mix my sand, etc., is that I have a box and put in the sand and then measure and put in the cement and mix well before I use any water. Then mix it thoroughly again. I also have a box of finer sand and with more cement for facing. I have the facing drier than the other so that it won't stick to the face. I sometimes mix Venetian red with my facing sand and it makes a nice red face and looks like red gravel. I also lay up one red one and one gray one for corners. Yours respectfully, IRA A. FOX.

The Improved Buckeye Cement Block Machine, Size 8x8x16 Inches



The above illustration shows the No. 1 size of Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, with stand or base fitted with cast iron pallet with core inserted. See page 77 for photographs of the Improved Buckeye Cement Block Machine as shown when opened up and the blocks removed from the machine

THE Improved Buckeye Hollow Cement Block Machine is constructed along the same general lines and principles followed by us in making the Standard Buckeye Machine, other than it is attached to the different shape and size stand or base. The stands used on the 8x8x16-inch, 8x10x16-inch and 8x12x16-inch sizes of the Improved Buckeye Hollow Cement Block Machine are exactly the same on each size of machine; the mould or flask is interchangeable and can be used with either outfit.

See page 56 for a general description of the Regular Buckeye Cement Block Machine, the range of work possible to turn out with this machine and its speed, ease of operation, etc. The 8x8x16-inch No. 1 size Improved Buckeye Cement Block Machine is so constructed that either cast iron or wood pallets may be used. We do not advise the use of wood pallets, especially where there is much work to be done with the machine. Every manufacturer of cement building blocks will find that money expended for cast iron pallets will prove a most profitable investment and the machine is only made to allow the use of wood pallets to meet the requirements of a few of our customers who may use the machines for making blocks for foundation work or who may buy a machine to make a lot of blocks for small buildings and who do not care to invest very much money in an outfit. The cast iron pallet for the 8x8x16-inch size Buckeye Machine weighs about 8 pounds. The wood pallet for the 8x8x16-inch size Buckeye Machine is 8½ inches wide, 20 inches long and 1 inch thick. A sample wood pallet is sent with the machine and you can easily make them yourself, or have them made in a local carpenter shop. If you use wood pallets, they should be made from the very best wood obtainable in your locality; that is, wood that is not liable to warp, and we recommend that they be well saturated with boiling hot linseed oil. This will have a tendency to prevent warping. Wood pallets should be grooved lengthwise, on the under side of the pallet. About three or four grooves, ⅛ or ¼ of an inch deep, will tend to prevent warping. We furnish the No. 1 size Improved Buckeye Cement Block Machine mounted on stand as shown above, and with an outfit as described on the following pages. This machine is interchangeable with the Combination Improved Buckeye Cement Block Machine outfit as shown on page 82.

The Improved Buckeye Hollow Cement Block Machine, Size 8x8x16 Inches, is Furnished Complete with the Following Outfit:

1 Stand and Flask complete as illustrated.
1 Face Plate for making whole blocks.
1 Face Plate of the same design for making halves and quarter blocks.
2 Core End Doors.
1 End Door to match face for return corners.
1 End Door to match the face plate for porch piers.
1 Core Gate for rear wall.
1 Core Gate for front wall or pallet.
1 Dividing Plate for making half blocks.
1 Dividing Plate for making quarter blocks.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Striker.
1 Double End Tamper.
1 Sample Wood Pallet.
1 Cast Iron Pallet, size, 8x8x16 inches.

We furnish any design of face plate specified in the following outfits:

Price List of Outfits for Improved Buckeye Cement Block Machine, Size 8x8x16 Inches

No. 63A1501 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 375 pounds. Price.......... **$27.35**

No. 63A1503 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 375 pounds. Price.......... **$27.35**

No. 63A1505 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 375 pounds. Price.......... **$27.35**

No. 63A1507 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 375 pounds. Price.......... **$27.35**

No. 63A1509 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 375 pounds. Price.......... **$27.35**

No. 63A1511 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 375 pounds. Price.......... **$27.35**

No. 63A1513 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 400 pounds. Price.......... **$31.85**

No. 63A1515 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight of complete outfit, 400 pounds. Price.......... **$31.85**

No. 63A1517 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight of complete outfit, 400 pounds. Price.......... **$31.85**

No. 63A1519 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight of complete outfit, 400 pounds. Price.......... **$31.85**

No. 63A1521 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight of complete outfit, 400 pounds. Price.......... **$31.85**

No. 63A1523 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight of complete outfit, 400 pounds. Price.......... **$31.85**

No. 63A1525 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$46.10**

No. 63A1527 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price.......... **$46.10**

Price List continued on following page

Price List Improved Buckeye, 8x8x16 Inches—Continued

No. 63A1529 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price..$46.10

No. 63A1531 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price..$46.10

No. 63A1533 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price..$46.10

No. 63A1535 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 975 pounds. Price..$46.10

No. 63A1537 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 1,025 pounds. Price..$50.60

No. 63A1539 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight, about 1,025 pounds. Price..$50.60

No. 63A1541 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight, about 1,025 pounds. Price..$50.60

No. 63A1543 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter block, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight, about 1,025 pounds. Price..$50.60

No. 63A1545 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight, about 1,025 pounds. Price..$50.60

No. 63A1547 Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight, about 1,025 pounds. Price..$50.60

The Improved Buckeye Machine is Interchangeable

The No. 1 size Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, is interchangeable with the No. 2 and No. 3 sizes of Improved Buckeye Hollow Cement Block Machine, that is, either of these moulds or flasks can be placed on the cast iron stand or base used with either size of machine. The face plates are exactly the same, and if you should have one of our Improved Buckeye Cement Block Machines, size 8x8x16 inches, and later on should decide to purchase a mould or set of attachments for making larger sized blocks, we can at any time furnish you a complete mould or flask, interchangeable with your stand and outfit as follows:

No. 63A1597 One Complete Flask or Mould for Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted up with one face plate for making whole blocks and one face plate of the same design for making half and quarter blocks, two core end doors, two end doors to match the face plate, two dividing plates, one cast iron pallet and one sample wood pallet. Size, 8x10x16 inches. Price..$20.50

Remember, the face plates are interchangeable with all sizes of the 16-inch Buckeye Cement Block Machines and you may select any design of face plate which you do not already have. Face plates must be included with this outfit, so do not neglect to specify the kind wanted.

No. 63A1598 One Complete Flask or Mould for Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted up with one face plate for making whole blocks, and one face plate of the same design for making half and quarter blocks, two core end doors, two end doors to match the face plate, two dividing plates and one cast iron pallet. Size 8x12x16 inches. Price..$25.50

Remember, the face plates are interchangeable with all sizes of the 16-inch Buckeye Cement Block Machines and you may select any design of face plate which you do not already have. Face plates must be included with this outfit, so do not neglect to specify the kind wanted.

Bay Window Attachments for Improved Buckeye Hollow Cement Block Machine, Size 8x8x16 Inches

We can furnish our adjustable bay window angle plate and attachments, which consist of a face plate with an adjustable angle attachment fitted to one end and two special end doors for making any degree of angle blocks in the following designs of face plates and prices:

No. 63A1301 Set of Complete Bay Window Attachments, Plain Face Design. Price....$4.50
No. 63A1302 Set of Complete Bay Window Attachments, Rock Face Design. Price.... 4.50
No. 63A1303 Set of Complete Bay Window Attachments, Panel Face Design. Price.... 4.50
No. 63A1304 Set of Complete Bay Window Attachments, Cobblestone Face Design. Price, 4.50
No. 63A1305 Set of Complete Bay Window Attachments, Tool Edge Rock Face Design. Price.... 4.50

Attachments for Making Circle Blocks on the Improved Buckeye Hollow Cement Block Machine, Size 8x8x16 Inches

We can furnish a radius of circle face plate in a number of different designs for making circle blocks. With this face plate are furnished two special end doors to complete the set of attachments. We can furnish these circle plates to make either an 8-foot, 10-foot or 12-foot circle for bay windows, etc. It requires a different set of attachments to make the different angles. We can furnish these circle plate attachments in the following designs and at the prices printed below:

No. 63A1351 Set of Complete Attachments for making 8-foot radius blocks, Plain Face Design. Price, complete....$4.50
No. 63A1353 Set of Complete Attachments for making 10-foot radius blocks, Plain Face Design. Price, complete.... 4.50
No. 63A1355 Set of Complete Attachments for making 12-foot radius blocks, Plain Face Design. Price, complete.... 4.50
No. 63A1357 Set of Complete Attachments for making 8-foot radius blocks, Rock Face Design. Price, complete.... 4.50
No. 63A1359 Set of Complete Attachments for making 10-foot radius blocks, Rock Face Design. Price, complete.... 4.50
No. 63A1361 Set of Complete Attachments for making 12-foot radius blocks, Rock Face Design. Price, complete.... 4.50

Price List of Extra Face Plates, End Doors, Pallets, Etc., for the Improved Buckeye Cement Block Machine, Size 8x8x16 Inches

No. 63A1101 Plain Face Plates to make whole blocks. Price, each....$1.50
No. 63A1102 Plain Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1176 Plain End Doors, right or left hand. Price, each.... .95
No. 63A1105 Medium Rock Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1106 Medium Rock Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1107 Rock Face Plates for making three-quarter blocks and one-eighth blocks. Price, each.... 1.50
No. 63A1178 Medium Rock End Doors, right or left hand. Price, each.... .95
No. 63A1111 Heavy Rock Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1112 Heavy Rock Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1114 Shallow Rock Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1115 Shallow Rock Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1118 Tool Edge Rock Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1119 Tool Edge Rock Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1180 Tool Edge End Doors, right or left hand. Price, each.... .95
No. 63A1122 Panel Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1123 Panel Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1182 Panel Face End Doors, right or left hand. Price, each.... .95
No. 63A1125 Tool Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1126 Tool Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1184 Tool Face End Plates, right or left hand. Price, each.... .95
No. 63A1137 Face Plates for making imitation pressed brick whole blocks. Price, each.... 1.50
No. 63A1138 Face Plates for making imitation pressed brick, halves and quarters. Price, each.... 1.50
No. 63A1190 End Doors for making imitation pressed brick design, right or left hand. Price, each.... .95
No. 63A1128 Cobblestone Face Plates, for whole blocks. Price, each.... 1.50
No. 63A1129 Cobblestone Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1186 Cobblestone End Doors, right or left hand. Price, each.... .95
No. 63A1132 Water Table Face Plates to make whole blocks. Price, each.... 1.50
No. 63A1133 Water Table Face Plates to make halves and quarters. Price, each.... 1.50
No. 63A1188 Water Table End Doors, right or left hand. Price, each.... .95
No. 63A1140 Ornamental Design Face Plate with whirlwind scroll for making whole blocks. Price, each.... 1.50

Price List continued on following page

Price List Buckeye Face Plates—Continued

No. 63A1141 Ornamental Design Face Plate with whirlwind scroll for making half and quarter blocks. Price, each 1.50

No. 63A1192 Ornamental Design End Door with whirlwind scroll, right or left hand. Price, each .... .95

No. 63A1144 Ornamental Face Plate with rope design on face for making whole blocks. Price, each 1.50

No. 63A1145 Ornamental Face Plate with rope design on face for making half and quarter blocks. Price, each 1.50

No. 63A1194 Ornamental End Door with rope design, right or left hand. Price, each... .95

No. 63A1151 Broken Ashler Face Plate, Style A, for making whole blocks. Price, each. 1.50

No. 63A1152 Broken Ashler Face Plate, Style B, for making whole blocks. Price, each. 1.50

No. 63A1153 Broken Ashler Face Plate, Style C, for making whole blocks. Price, each. 1.50

No. 63A1154 Broken Ashler Face Plate, Style D, for making whole blocks. Price, each. 1.50

No. 63A1155 Broken Ashler Face Plate, Style E, for making whole blocks. Price, each. 1.50

NOTE—To make half and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a whole block produces very desirable results.

No. 63A1196 Broken Ashler End Doors, right or left hand. Price, each........ .95

No. 63A1550 Pallets for regular blocks. Weight, about 8 pounds each. Size 8x8x16 inches. Price, each........ .25

No. 63A1100 Double End Tamper. Price, each........ .80

Price List of Attachments and Extras for Making 4-inch Course Blocks on the Improved Buckeye Cement Block Machine, Size 8x8x16 Inches

We can furnish special face plates for the Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, for making 4-inch course blocks (4x8x16 inches) in either plain face, rock face, panel face or tool face design. It requires two sets of special end doors and two face plates to make a complete outfit for making 4-inch blocks. You will need one face plate for making whole blocks, 4x8x16 inches, and you should have another face plate of the same design for making halves and quarters, also one pair of core end doors and another pair of end doors to match the face plate. You will require half and quarter blocks, and money spent for a face plate to make fractional blocks is well invested and will enable you to produce the very best results.

No. 63A1201 Plain Face Plates for making 4-inch course blocks, size 8x8x16 inches. Makes two 4-inch blocks at a time. Price, each........ $1.50

No. 63A1202 Plain Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each 1.50

No. 63A1203 Rock Face Plates for making 4-inch course blocks, size 8x8x16 inches. Makes two 4-inch blocks at a time. Price, each........ 1.50

No. 63A1204 Rock Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each........ 1.50

No. 63A1205 Panel Face Plates for making 4-inch course blocks, size 8x8x16 inches. Makes two 4-inch blocks at a time. Price, each........ 1.50

No. 63A1206 Panel Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each 1.50

No. 63A1207 Tool Face Plates for making 4-inch course blocks, size 8x8x16 inches. Makes two 4-inch blocks at a time. Price, each 1.50

No. 63A1208 Tool Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each........ 1.50

No. 63A1251 End Doors, Plain Face Design, for making 4-inch course blocks, right and left hand. Price, per pair........ 1.00

No. 63A1252 End Doors, Rock Face Design, for making 4-inch course blocks, right and left hand. Price, per pair 1.00

No. 63A1253 End Doors, Panel Face Design, for making 4-inch course blocks, right and left hand. Price, per pair........ 1.00

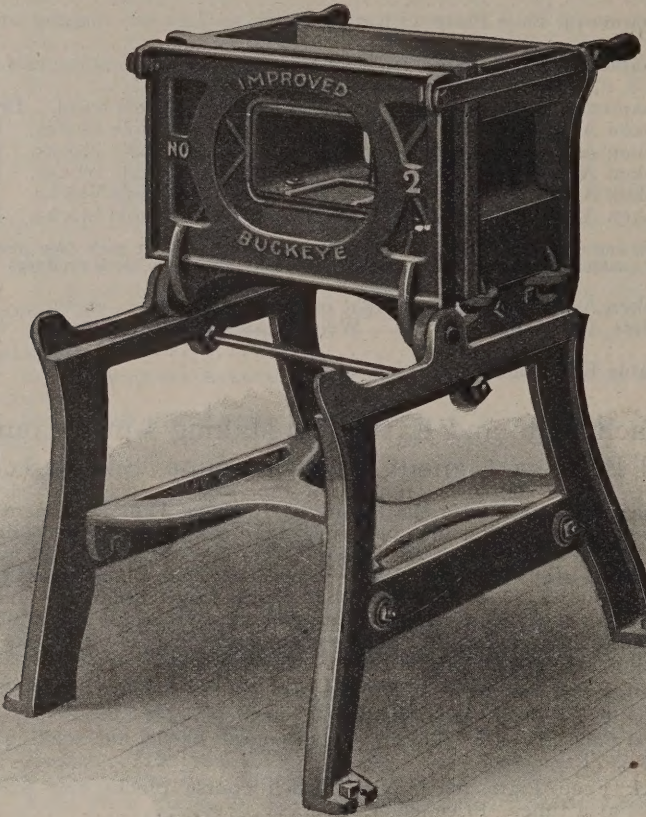
No. 63A1254 End Doors, Tool Face Design, for making 4-inch course blocks, right and left hand. Price, per pair........ 1.00

No. 63A1255 Core End Doors (makes the cove end on regular blocks) for making 4-inch course blocks. **You will need one pair of this style of end doors with any 4-inch outfit.** Right and left hand, complete. Price, per pair 1.00

No. 63A1256 Special Inside Core Pallets, used when making two 4-inch course blocks at one time. Cast iron. Price, each........ .25

These inside or divisional pallets should be used where you have any large number of 4-inch course blocks to make. With the use of these dividing pallets you can work your machine to its greatest capacity.

The Improved Buckeye Cement Block Machine, Size 8x10x16 Inches



This illustration shows our No. 2 size of Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, mounted on stand or base, and fitted with cast iron pallet. See page 77 for photographs of the Improved Buckeye Cement Block Machine as shown when opened up and the block removed from the machine

THE No. 2 size Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, is constructed along the same general lines as the Standard Buckeye Machine and the No. 1 size Improved Buckeye Cement Block Machine. The No. 2 size Improved Buckeye Cement Block Machine makes either a hollow block with one large single core or a solid block as desired. The actual size of the block is 7¾ inches high by 15¾ inches long and 10 inches thick in the wall. We allow a fraction of an inch on both the height and length of the block for a mortar joint. This size of block will lay up 8x16 inches in the wall. An 8-inch wall is sufficiently heavy for one and two-story residences and small store buildings, and in the country and smaller towns there are more 8-inch walls built than practically all of the other sizes put together. In many of the larger towns and in the cities, the building laws require heavier walls, hence we have devised the Improved Buckeye Cement Block Machine with a view of furnishing a complete machine to every contractor and builder and to any person wanting a complete outfit at a moderate price and at the same time have a machine that will have a capacity and range of work of sufficient scope to fill all requirements. With our complete line of three sizes of Improved Buckeye Cement Block Machines you can build a 12-inch foundation and the walls 8 and 10 inches, as wanted. Every block will lay up 8 inches by 16 inches face in the wall. No matter whether you use blocks that are 8 inches thick, 10 inches thick or 12 inches thick, the face of the blocks is always the same. Until we secured this line of cement block machines other manufacturers were making their 8-inch blocks 16 inches long, their 10-inch blocks would be either 20 or 24 inches long and their 12-inch blocks would be made from 24 to 36 inches long. Blocks of this size require a derrick or hoist for laying them in the wall, while with our line of combination machines every block is 16 inches long, so that one man can handle them at the machine and lay them up in the wall. This means a direct saving of the wages of one man. The 8x10x16 size Improved Buckeye Cement Block Machine uses either a cast iron or wood pallet. The cast iron pallet weighs about 12 pounds. The wood pallet should be made 10½ inches wide, 18 inches long and 2 inches thick. If you decide to use wood pallets, make them out of the best thoroughly seasoned lumber that you can obtain in your locality, and it will pay you to saturate them thoroughly with boiling hot linseed oil. If you have a large vat or tank that you could boil them in, you will add much to the life of the pallet and insure accuracy in making your blocks and save the expense of having many blocks broken. As the pallets are 2 inches thick on this size of machine, it might be cheaper for you to throw away the old pallets when they commence warping and make new ones. At any rate, if you use wood pallets, be sure that they do not warp or you will always have trouble with your blocks breaking and being "out of true." Iron pallets are best and we recommend their use.

The Improved Buckeye Hollow Cement Block Machine, Size 8x10x16 Inches, Furnished Complete with the Following Outfit:

1 Face Plate for making whole blocks.
1 Face Plate of the same design for making half and quarter blocks.
2 Core End Doors.
1 End Door to match face for return corners.
1 End Door to match the face plate, for porch piers.
1 Core Gate for rear wall.
1 Core Gate for front wall or pallet.
1 Dividing Plate for making half blocks.
1 Dividing Plate for making quarter blocks.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Striker.
1 Double End Tamper.
1 Sample Wood Pallet.
1 Cast Iron Pallet, size 8x10x16 inches.

Price List of Buckeye Cement Block Machine Outfits, Size 8x10x16 Inches

No. 63A1600 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with any style of face plate and ends for making whole blocks, half and quarter blocks and with one cast iron pallet and one sample wood pallet. Weight, 300 pounds. Price, complete....$25.25

Be sure to specify whether plain, rock, panel, tool, broken ashler or cobblestone face is wanted.

No. 63A1601 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 475 pounds. Price..$33.95

No. 63A1603 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 475 pounds. Price..$33.95

No. 63A1605 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 475 pounds. Price..$33.95

No. 63A1607 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 475 pounds. Price..$33.95

No. 63A1609 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 475 pounds. Price..$33.95

No. 63A1611 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 475 pounds. Price..$33.95

No. 63A1613 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 25 cast iron pallets, also a complete set of bay window angle plates and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 515 pounds. Price..$38.45

No. 63A1615 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plates and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight of complete outfit, 515 pounds. Price..$38.45

No. 63A1617 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight of complete outfit, 515 pounds. Price..$38.45

No. 63A1619 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight of complete outfit, 515 pounds. Price..$38.45

Price List continued on following page

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Price List of Improved Buckeye, Size 8x10x16 Inches—Continued

No. 63A1621 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight of complete outfit, 515 pounds. Price.......... **$38.45**

No. 63A1623 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight of complete outfit, 515 pounds. Price.......... **$38.45**

No. 63A1625 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,575 pounds. Price.......... **$56.45**

No. 63A1627 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,575 pounds. Price.......... **$56.45**

No. 63A1629 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,575 pounds. Price.......... **$56.45**

No. 63A1631 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,575 pounds. Price.......... **$56.45**

No. 63A1633 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,575 pounds. Price.......... **$56.45**

No. 63A1635 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,575 pounds. Price.......... **$56.45**

No. 63A1637 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 100 cast iron pallets, also a complete set of bay window angle plates and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 1,625 pounds. Price.......... **$60.95**

No. 63A1639 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight, about 1,625 pounds. Price.......... **$60.95**

No. 63A1641 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight, about 1,625 pounds. Price.......... **$60.95**

No. 63A1643 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight, about 1,625 pounds. Price.......... **$60.95**

No. 63A1645 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight, about 1,625 pounds. Price.......... **$60.95**

No. 63A1647 Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight, about 1,625 pounds. Price.......... **$60.95**

WELL PLEASED WITH HIS BUCKEYE MACHINE.

Oconto Falls, Wis., Jan. 18, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—At your request to write you concerning your Buckeye Cement Block Machine which I am using, in reply would say the machine is all right and I am well pleased with it. The principal thing in manufacturing good cement blocks is in the mixing of the material used for making the blocks. The machine will make a good block, of the proper size and shape, just right for one man to handle.

On account of the extremely cold weather in this section of the country, it is best to put on furring strips for lath and plaster so as to form a dead air space between the wall and the plaster to prevent frost in winter time and dampness in summer time. The blocks can be painted and waterproofed on the outside to prevent this, but I am using the regular blocks as made on your cement block machine.

Yours truly, J. C. VOLK.

The Improved Buckeye Cement Block Machine is Interchangeable

The No. 2 size Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, is interchangeable with the No. 1 or No. 3 sizes of Improved Buckeye Hollow Cement Block Machine, that is, either of these moulds or flasks can be placed on the cast iron stand or base used with either size of machine. The face plates are exactly the same, and if you should have one of our Improved Buckeye Cement Block Machines, size 8x10x16 inches, and later on should decide to purchase a flask or attachment for making larger or smaller sized blocks, we can at any time furnish you a complete mould or flask, interchangeable with your stand and outfit as follows:

No. 63A1697 One Complete Flask or Mould for Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted up with one face plate for making whole blocks and one face plate of the same design for making half and quarter blocks, two core end doors, two end doors to match the face plates, two divided plates and one cast iron pallet, size 8x8x16 inches. Price. . **$16.50**

Remember, the face plates are interchangeable with all sizes of the 16-inch Buckeye Cement Block Machines and you may select any design of face plate which you do not already have. Two face plates must be included with this outfit, so do not neglect to specify the kind wanted.

No. 63A1698 One Complete Flask or Mould for Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with one face plate for making whole blocks and one face plate of the same design for making half and quarter blocks, two core end doors, two end doors to match the face plate, two dividing plates and one cast iron pallet, size 8x12x16 inches. Price. . . .**$25.50**

Remember, the face plates are interchangeable with all sizes of the 16-inch Buckeye Cement Block Machines and you may select any design of face plate which you do not already have. Two face plates must be included with this outfit, so do not neglect to specify the kind wanted.

Price List of Extra Face Plates, End Doors, Pallets, etc., for the Improved Buckeye Hollow Cement Block Machine, Size 8x10x16 Inches

No. 63A1101	Plain Face Plates to make whole blocks. Price, each	**$1.50**
No. 63A1102	Plain Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1676	Plain End Doors, right or left hand. Price, each	**1.15**
No. 63A1105	Medium Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1106	Medium Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1107	Rock Face Plates for making three-quarter blocks and one-eighth blocks. Price, each	**1.50**
No. 63A1678	Medium Rock End Doors, right or left hand. Price, each	**1.15**
No. 63A1111	Heavy Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1112	Heavy Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1114	Shallow Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1115	Shallow Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1118	Tool Edge Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1119	Tool Edge Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1680	Tool Edge Rock Face End Doors, right or left hand. Price, each	**1.15**
No. 63A1122	Panel Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1123	Panel Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1682	Panel Face End Doors, right or left hand. Price, each	**1.15**
No. 63A1125	Tool Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1126	Tool Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1684	Tool End Plates, right or left hand. Price, each	**1.15**
No. 63A1137	Face Plates for making imitation pressed brick, whole blocks. Price, each,	**1.50**
No. 63A1138	Face Plates for making imitation pressed brick, halves and quarters. Price, each	**1.50**
No. 63A1690	End Doors for making imitation pressed brick design, right or left hand. Price, each	**1.15**
No. 63A1128	Cobblestone Face Plate for whole blocks. Price, each	**1.50**
No. 63A1129	Cobblestone Face Plate to make halves and quarters. Price, each	**1.50**
No. 63A1686	Cobblestone End Doors, right or left hand. Price, each	**1.15**
No. 63A1132	Water Table Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1133	Water Table Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1688	Water Table End Doors, right or left hand. Price, each	**1.15**
No. 63A1140	Ornamental Design Face Plate, with whirlwind scroll for making whole blocks. Price	**1.50**
No. 63A1141	Ornamental Design Face Plate, with whirlwind scroll for making half and quarter blocks. Price	**1.50**
No. 63A1692	Ornamental Design End Doors, with whirlwind scroll, right or left hand. Price, each	**1.15**
No. 63A1144	Ornamental Face Plate, with rope design on face for making whole blocks. Price	**1.50**
No. 63A1145	Ornamental Face Plate, with rope design on face for making half and quarter blocks. Price	**1.50**

Price List continued on following page

Price List of Extras, 8x10x16-inch Improved Buckeye—Continued

No. 63A1694 Ornamental End Doors, with rope design, right or left hand. Price, each..**$1.15**
No. 63A1151 Broken Ashler Face Plate, Style A, for making whole blocks. Price, each.. **1.50**
No. 63A1152 Broken Ashler Face Plate, Style B, for making whole blocks. Price, each.. **1.50**
No. 63A1153 Broken Ashler Face Plate, Style C, for making whole blocks Price, each.. **1.50**
No. 63A1154 Broken Ashler Face Plate, Style D, for making whole blocks. Price, each.. **1.50**
No. 63A1155 Broken Ashler Face Plate, Style E, for making whole blocks. Price, each.. **1.50**

NOTE — To make halves and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4 inch) placed on either end of a whole block, produce very desirable results.

No. 63A1696 End Doors, right or left hand. Broken Ashler design. Price, each....... **1.15**

No. 63A1650 Pallets for regular blocks, weight about 12 pounds each. Size 8x10x16 inches. Price, each.......... **.37**

No. 63A1100 Double End Tamper. Price, each.......... **.80**

Price List of Attachments and Extras for Making 4-inch Course Blocks on the Improved Buckeye Cement Block Machine, Size 8x10x16 Inches

We can furnish special face plates for the Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, for making 4-inch course blocks (4x10x16-inch) in either plain face, rock face, panel face or tool face design. It requires two sets of special end doors and two face plates to make a complete outfit for making 4-inch blocks. You will need one face plate for making whole blocks, 4x8x16 inches, and you should have another face plate of the same design for making halves and quarters, also one pair of core end doors and another pair of end doors to match the face plate. You will require half and quarter blocks, and money spent for a face plate to make fractional blocks is well invested and will enable you to produce the very best results.

No. 63A1201 Plain Face Plates for making 4-inch course blocks, size 8x10x16 inches. Makes two 4-inch blocks at a time. Price, each..........**$1.50**

No. 63A1202 Plain Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... **1.50**

No. 63A1203 Rock Face Plates for making 4-inch course blocks, size 8x10x16 inches. Makes two 4-inch blocks at a time. Price, each.......... **1.50**

No. 63A1204 Rock Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... **1.50**

No. 63A1205 Panel Face Plates for making 4-inch course blocks, size 8x10x16 inches. Makes two 4-inch blocks at a time. Price, each.......... **1.50**

No. 63A1206 Panel Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... **1.50**

No. 63A1207 Tool Face Plates for making 4-inch course blocks, size 8x10x16 inches. Makes two 4-inch blocks at a time. Price, each.......... **1.50**

No. 63A1208 Tool Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each.......... **1.50**

No. 63A1651 End Doors, Plain Face Design, for making 4-inch course blocks, right and left hand. Price, per pair.......... **1.00**

No. 63A1652 End Doors, Rock Face Design, for making 4-inch course blocks, right and left hand. Price, per pair.......... **1.00**

No. 63A1653 End Doors, Panel Face Design, for making 4-inch course blocks, right and left hand. Price, per pair.......... **1.00**

No. 63A1654 End Doors, Tool Face Design, for making 4-inch course blocks, right and left hand. Price, per pair.......... **1.00**

No. 63A1655 Core End Doors (makes the cove end on regular blocks), for making 4-inch course blocks. **You will need one pair of this style of End Doors with any 4-inch outfit.** Right and left hand, complete. Price, per pair.......... **1.00**

No. 63A1656 Special Inside Core Pallets, used when making two 4-inch course blocks at one time. Cast iron. Price, each.......... **.25**

These inside or divisional pallets should be used where you have any large number of 4-inch course blocks to make. With the use of these dividing pallets you can work your machine to its full capacity.

Bay Window Attachments for the Improved Buckeye Hollow Cement Block Machine, Size 8x10x16 Inches

We can furnish our adjustable bay window angle plate and attachments, which consist of a face plate with an adjustable angle attachment fitted to one end and two special end doors for making any degree of angle blocks, in the following designs of face plates and prices:

No. 63A1661 Set of Complete Bay Window Attachments. Plain Face Design. Price.....**$4.50**
No. 63A1662 Set of Complete Bay Window Attachments. Rock Face Design. Price..... **4.50**
No. 63A1663 Set of Complete Bay Window Attachments. Panel Face Design. Price.... **4.50**
No. 63A1664 Set of Complete Bay Window Attachments. Cobblestone Face Design. Price, **4.50**
No. 63A1665 Set of Complete Bay Window Attachments. Tool Edge Rock Face Design. Price.......... **4.50**

Attachments for Making Circle Blocks on the Improved Buckeye Hollow Cement Block Machine, Size 8x10x16 Inches

We can furnish a radius or circle face plate in a number of different designs for making circle blocks. With this face plate are furnished two special end doors to complete the set of attachments. We can furnish these circle plates to make either an 8-foot, 10-foot or 12-foot circle for bay windows, etc. It requires a different set of attachments to make the different angles. We can furnish these circle plate attachments in the following designs and at the prices printed below:

No. 63A1670	Set of Complete Attachments for making 8-foot radius blocks. Plain Face Design. Price, complete	$4.50
No. 63A1671	Set of Complete Attachments for making 10-foot radius blocks. Plain Face Design. Price, complete	4.50
No. 63A1672	Set of Complete Attachments for making 12-foot radius blocks. Plain Face Design. Price, complete	4.50
No. 63A1673	Set of Complete Attachments for making 8-foot radius blocks. Rock Face Design. Price, complete	4.50
No. 63A1674	Set of Complete Attachments for making 10-foot radius blocks. Rock Face Design. Price, complete	4.50
No. 63A1675	Set of Complete Attachments for making 12-foot radius blocks. Rock Face Design. Price, complete	4.50

BUCKEYE PLEASES BECAUSE IT TAKES LESS CEMENT, LESS SAND AND LESS WORK.

Providence, Ky., Dec. 22, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In regard to your letter received some time ago concerning the Buckeye Cement Block Machine purchased from you some time ago, wish to say I am well pleased with it. I like the Buckeye Machine because it takes less cement, less sand and less work.

Yours truly,
D. L. WALLACE.

A LARGE USER IS WELL PLEASED WITH THE BUCKEYE.

THE KNICKERBOCKER COAL & ICE CO.
Wholesale and Retail Dealers in Best Grades of
Hard and Soft Coal, Coke and Michigan Ice.

Elyria, Ohio., Dec. 15, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—In answer to your letter of inquiry in regard to the Buckeye Cement Block Machine I purchased from you, will say it is giving very good satisfaction. Have built several foundations and am now building a house, first story cement blocks made on the Buckeye Cement Block Machine. Will mail you a photograph of same when complete.

Yours very truly,
H. J. NEIPFOOT.

THE GREATEST VALUE IN OUR CATALOGUE.

Limon, Colo., Nov. 18, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Received the Buckeye Cement Block Machine some three months back and would say it is the biggest money value of anything in your big catalogue. I can make as good or better blocks than on other machines that cost $100.00 to $300.00. Can make from 100 to 150 with two men in a day.

I have made 2,000 blocks and lived in one of the houses three months and I do not find the walls damp in the least. The mixture for blocks was five parts sand and one part cement.

Yours truly,
J. B. HAWLEY.

THE BUCKEYE CEMENT BLOCK MACHINE IN A CLASS BY ITSELF.

Grove City, Pa., Jan. 2, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—You wrote me some time ago relative to the Buckeye Cement Block Machine which I purchased from you last season. Your Buckeye Cement Block Machine is all right and if I could not get another like it I would not take twice what I paid for it. It makes a block of proper proportion, a block that can be handled by one man. It is a block that one mason can lay in the wall without the necessity of a helper. One man can make seventy-five blocks in eight hours and do his own mixing by hand with the Buckeye Cement Block Machine. The Buckeye Cement Block Machine is in a class by itself. It is at the head of the list and will remain there. I want to order some other plates and attachments to make blocks 4x8x16 inches.

Yours truly, R. M. MILLER.

MAKES ONE HUNDRED BLOCKS A DAY.

Monett, Mo., Jan. 12, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—I received the Buckeye Cement Block Machine in due time and have been using it about a month and find it all right. I can make 100 blocks in a day and think this is as good as any other machine can do.

Yours truly, DUDLEY CRUMLY.

THE BUCKEYE VERY SATISFACTORY AND MAKES A FINE BLOCK.

Ainsworth, Iowa, Dec. 2, 1906.

Sears, Roebuck & Co., Chicago, Ill.

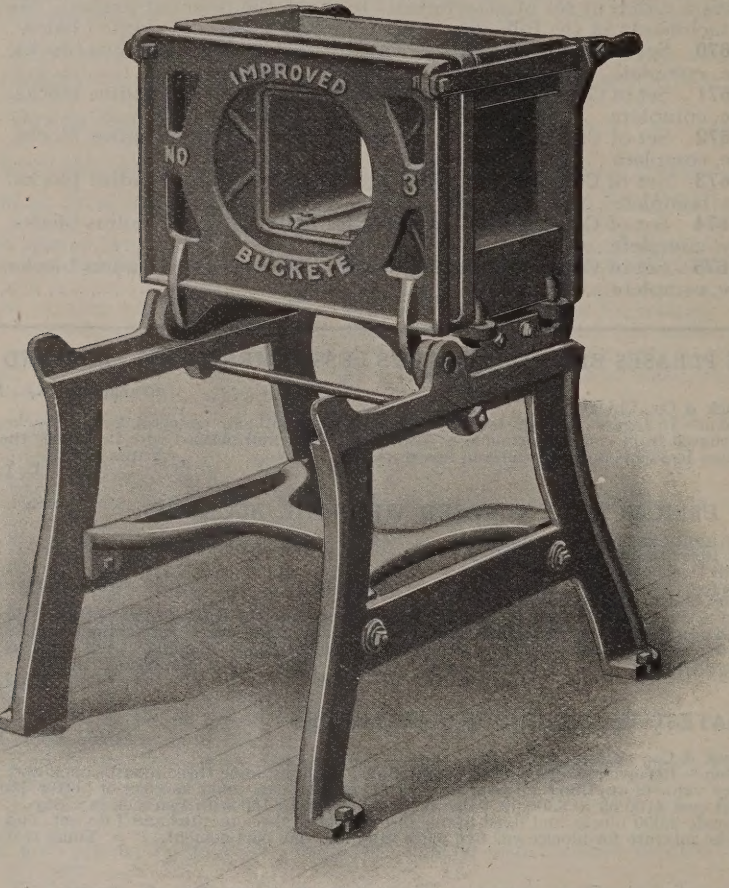
Sirs:—A few days ago I received a letter from you stating that you would like to know how I like the Buckeye Cement Block Machine I purchased from you. I like it fine. It is as good as any I ever saw. I made the blocks for my cellar this summer and they are all right so far. I sold the machine to Mr. Balmer and he makes blocks to sell.

A neighbor built an ice house and it is as good as any he ever saw. The man sells the blocks as fast as he can make them. Your machine is very satisfactory and makes a fine block. It is easy to operate.

Yours truly, HENRY LEFFLER.

Improved Buckeye Cement Block Machine

Size 8x12x16 Inches

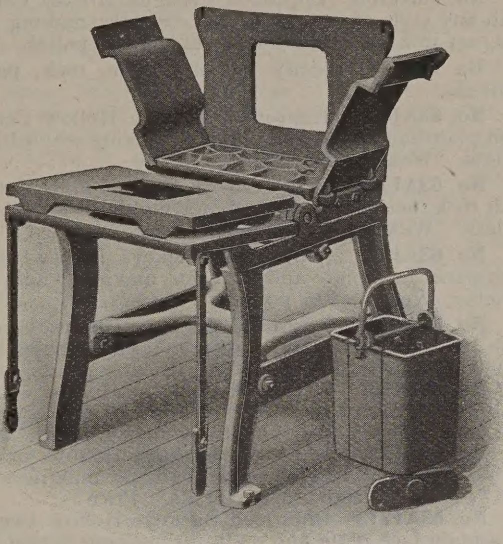


The above illustration shows the No. 3 size of Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, mounted on stand or base and fitted with cast iron pallet. See page 77 for photographs of the Improved Buckeye Cement Block Machine as shown when opened up and the block removed from the machine

EVERY building contractor and every manufacturer of cement building blocks should have a machine capable of turning out as large work as might be needed on any job or building liable to be erected in his vicinity. In some of the larger cities the building laws now require 12-inch foundations for any structure two stories in height, especially in store buildings, warehouses and large buildings of any kind. To meet this condition, we have had the Improved Buckeye Hollow Cement Block Machine made in a larger size, and with this machine you can make building blocks for a wall 12 inches thick. The face of the block will be 8x16 inches in the wall, the same as the No. 1 and No. 2 sizes of the machine. The 8x12x16-inch Improved Buckeye Machine is made to use either wood or cast iron pallets. We recommend the use of cast iron pallets in every machine where there is much work to be done. The 8x12x16 size machine will probably be used more for making foundation blocks than the other two machines, and with that end in view, we have had it built so that wood pallets may be used, thus reducing the cost of the outfit. The wood pallets for this machine should be 12½ inches wide, 18 inches long and 2 inches thick. They should be made of thoroughly seasoned wood; use the best wood obtainable for making these pallets. Two or three good coats of boiling hot linseed oil will add much to the life of the wood pallet and have a tendency to prevent it from warping.

Every builder or contractor, every manufacturer of cement building blocks should be able to turn out 12-inch blocks for foundation work, 10-inch blocks for the first story and 8-inch blocks for the second story. With this kind of an outfit you can then complete any specification which may come. Remember, the No. 1 size, No. 2 size and No. 3 size of Improved Buckeye use the same face plate. If you buy a number of different pattern of face plates, they are interchangeable with every size of 16-inch Buckeye Cement Block Machine.

This feature alone is worth much to you because you do not have to buy extra face plates every time you want to make a different size of block. Unlike other machines, we have tried to build our entire line of Buckeye Machines so that practically all of the machines and parts are interchangeable, and this is where we save you so much money on your outfit. Instead of selling you three different sizes of machines at high prices for each outfit, we can furnish three machines practically in one, and cost of the three separate machines will be considerably less than other concerns will charge you for their smallest size and cheapest outfit. We recommend the use of a separate stand for each machine or mould. We believe it would be more satisfactory for you to buy three complete machines like our No. 1, No. 2 and No. 3 Improved Buckeye Machines, described on these pages, a machine and complete outfit for every size of block, which would enable you to operate three machines with three different sets of men, and if you choose, on three separate jobs or locations at the same time. Many contractors and builders now take the machine to the place where the building is to be erected, and make the blocks on the ground, as it costs less to haul the sand and gravel and cement than it will to deliver the blocks after they are made. If you have three separate machines, you can use one size outfit on one particular job today and move the machine to another job tomorrow, as your work requires.



The above illustration shows the large size (8x12x16-inch) Improved Buckeye Hollow Cement Block Machine, mounted on a stand or base with the core removed and the machine opened up as it appears after a block has been made and removed and a new cast iron pallet inserted for the next block. The machine shown is fitted up with a cobblestone face plate and with two core end doors Note how easy it is to remove the block from the machine and the extremely simple manner of releasing the end doors and back wall.

Remember, the No. 3 size Improved Buckeye Hollow Cement Block Machine makes a block to lay up a 12-inch wall and the face of the blocks is 8 inches high and 16 inches long. One man can carry these blocks away from the machine and one man can lay them in the wall, which means a considerable saving to you in the cost of labor, because one man will do the work that it requires two men to do with blocks made on other machines that turn them out 20, 24 and 30 inches long. Figure out this saving on all your future contracts when making blocks on our line of 16-inch machines; besides the outward appearance of the wall is absolutely uniform, every block being 8 inches high and 16 inches long.

The Improved Buckeye Hollow Cement Block Machine, Size 8x12x16 inches, is Furnished Complete with the Following Outfit:

1 Face Plate for making whole blocks.
1 Face Plate of the same design for making halves and quarter blocks.
2 Core End Doors.
1 End Door to match face for return corners.
1 End Door to match the face plate, for porch piers.
1 Core Gate for rear wall.
1 Core Gate for front wall or pallet.
1 Dividing Plate for making half blocks.
1 Dividing Plate for making quarter blocks.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Striker.
1 Double End Tamper.
1 Sample Wood Pallet.
1 Cast Iron Pallet, size 8x12x16 inches

WOULD NOT TAKE $150.00 FOR HIS BUCKEYE IF HE COULD NOT GET ANOTHER.

2123 Military Ave., Omaha, Neb., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:— I received the Buckeye Cement Block Machine that I ordered of you in good shape, and must say that I am very much pleased with it, and it does everything that you recommended it would do. In my estimation it makes an ideal block for building and foundation purposes. Before I sent to you for the machine I tried to buy one here, and the least price quoted to me was $120.00 up to $300.00, and I find and have proven beyond all doubt that your machine will make just as good and just as many blocks in a day as their high priced machines will make, and with the same amount of help. I must say that I am thoroughly pleased with it and would not take $150.00 and be without it.

My experience with buildings erected with cement building blocks proved to me that they can be plastered right on to the block without being lathed and plastered, providing the face of the block is made rich enough with cement. I use two parts of sand to one part of cement in most cases; but sometimes use equal parts of sand and cement for facing. This would make a wall far better than natural stone itself would be.

Yours truly, W. E. MERRITT.

Price List of Outfits for Improved Buckeye Cement Block Machine, Size 8x12x16 Inches

No. 63A1700 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with any style of face plate and ends for making whole blocks, half and quarter blocks, and with one cast iron pallet and one sample wood pallet. Price, complete........................ **$30.45**

Be sure to specify whether plain, rock, panel, tool, broken ashler or cobblestone face is wanted.

No. 63A1701 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 525 pounds. Price........................ **$40.95**

No. 63A1703 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 525 pounds. Price........................ **$40.95**

No. 63A1705 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 525 pounds. Price........................ **$40.95**

No. 63A1707 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with tool face plates and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 525 pounds. Price........................ **$40.95**

No. 63A1709 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 525 pounds. Price........................ **$40.95**

No. 63A1711 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets. Weight, 525 pounds. Price........................ **$40.95**

No. 63A1713 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 565 pounds. Price........................ **$45.45**

No. 63A1715 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight of complete outfit, 565 pounds. Price........................ **$45.45**

No. 63A1717 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight of complete outfit, 565 pounds. Price........................ **$45.45**

No. 63A1719 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight of complete outfit, 565 pounds. Price........................ **$45.45**

No. 63A1721 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight of complete outfit, 565 pounds. Price........................ **$45.45**

No. 63A1723 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 25 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight of complete outfit, 565 pounds. Price........................ **$45.45**

No. 63A1725 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks, with 100 cast iron pallets. Weight, 1,625 pounds. Price........................ **$73.20**

No. 63A1727 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,625 pounds. Price........................ **$73.20**

No. 63A1729 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,625 pounds. Price........................ **$73.20**

No. 63A1731 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,625 pounds. Price........................ **$73.20**

No. 63A1733 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with broken ashler face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,625 pounds. Price........................ **$73.20**

Price List Improved Buckeye, Size 8x12x16 Inches—Continued

No. 63A1735 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets. Weight, 1,625 pounds. Price..$73.20

No. 63A1737 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with plain face plate and ends for making whole blocks, half and quarter blocks for foundation work and inside walls, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with plain face and adjustable to any degree or angle. Weight of complete outfit, 1,665 pounds. Price..$77.70

No. 63A1739 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with rock face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with rock face and adjustable to any degree or angle. Weight, about 1,665 pounds. Price..$77.70

No. 63A1741 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with panel face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with panel face and adjustable to any degree or angle. Weight, about 1,665 pounds. Price..$77.70

No. 63A1743 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with broken ashler face and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with broken ashler face and adjustable to any degree or angle. Weight, about 1,665 pounds. Price..$77.70

No. 63A1745 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with tool face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with tool face and adjustable to any degree or angle. Weight, about 1,665 pounds. Price..$77.70

No. 63A1747 Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, fitted with cobblestone face plate and ends for making whole blocks, half and quarter blocks, and 100 cast iron pallets, also a complete set of bay window angle plate and attachments for making bay window blocks with cobblestone face and adjustable to any degree or angle. Weight, about 1,665 pounds. Price..$77.70

The Improved Buckeye Cement Block Machine is Interchangeable

The No. 3 size Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, is interchangeable with the No. 1 or No. 2 size of Improved Buckeye Hollow Cement Block Machine, that is, either of these moulds or flasks can be placed on the cast iron stand or base used with either size of machine. The face plates are exactly the same and if you should have one of our Improved Buckeye Hollow Cement Block Machines, size 8x12x16 inches, and later on should decide to purchase a flask or attachments for making larger sized blocks, we can at any time furnish you a complete mould or flask, interchangeable with your stand and outfit as follows:

No. 63A1797 One Complete Flask or Mould for Improved Buckeye Hollow Cement Block Machine, size 8x8x16 inches, fitted up with one face plate for making whole blocks and one face plate of the same design for making half and quarter blocks, two core end doors, two end doors to match the face plate, two dividing plates and one cast iron pallet, size 8x8x16 inches. Price.**$16.50**

Remember, the face plates are interchangeable with all sizes of the 16-inch Buckeye Cement Block Machines and you may select any design of face plate which you do not already have. Face plates must be included with this outfit, so do not neglect to specify the kind wanted.

No. 63A1798 One Complete Flask or Mould for Improved Buckeye Hollow Cement Block Machine, size 8x10x16 inches, fitted with one face plate for making whole blocks and one face plate of the same design for making half and quarter blocks, two core end doors, two end doors to match the face plate, two dividing plates and one cast iron pallet, size 8x10x16 inches. Price.**$20.50**

Remember, the face plates are interchangeable with all sizes of the 16-inch Buckeye Cement Block Machines and you may select any design of face plate which you do not already have. Face plates must be included with this outfit, so do not neglect to specify the kind wanted.

Bay Window Attachments for Improved Buckeye Hollow Cement Block Machine, Size 8x12x16 Inches

We can furnish our adjustable bay window angle plate and attachments, which consist of a face plate with an adjustable angle attachment fitted to one end and two special end doors for making any degree of angle blocks, in the following designs of face plates and prices:

No. 63A1761 Set of Complete Bay Window Attachments. Plain Face Design. Price...$4.50

No. 63A1762 Set of Complete Bay Window Attachments. Rock Face Design. Price... 4.50

No. 63A1763 Set of Complete Bay Window Attachments. Panel Face Design. Price... 4.50

No. 63A1764 Set of Complete Bay Window Attachments. Cobblestone Face Design. Price.. 4.50

No. 63A1765 Set of Complete Bay Window Attachments. Tool Edge Rock Face Design. Price.. 4.50

Attachments for Making Circle Blocks on the Improved Buckeye Hollow Cement Block Machine, Size 8x12x16 Inches

We can furnish a radius or circle face plate in a number of different designs for making circle blocks. With this face plate are furnished two special end doors to complete the set of attachments. We can furnish these circle plates to make either an 8-foot, 10-foot or 12-foot circle for bay windows, etc. It requires a different set of attachments to make the different angles. We can furnish these circle plate attachments in the following designs and at the prices printed below:

No. 63A1770	Set of Complete Attachments for making 8-foot radius blocks. Plain Face Design. Price, complete	**$4.50**
No. 63A1771	Set of Complete Attachments for making 10-foot radius blocks. Plain Face Design. Price, complete	**4.50**
No. 63A1772	Set of Complete Attachments for making 12-foot radius blocks. Plain Face Design. Price, complete	**4.50**
No. 63A1773	Set of Complete Attachments for making 8-foot radius blocks. Rock Face Design. Price, complete	**4.50**
No. 63A1774	Set of Complete Attachments for making 10-foot radius blocks. Rock Face Design. Price, complete	**4.50**
No. 63A1775	Set of Complete Attachments for making 12-foot radius blocks. Rock Face Design. Price, complete	**4.50**

Price List of Extra Face Plates, End Doors, Pallets, etc., for the Improved Buckeye Cement Block Machine, Size 8x12x16 Inches

No. 63A1101	Plain Face Plates to make whole blocks. Price, each	**$1.50**
No. 63A1002	Plain Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1776	Plain End Doors, right or left hand. Price, each	**1.20**
No. 63A1105	Medium Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1106	Medium Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1107	Medium Rock Face Plates for making three-quarter blocks and one-eighth blocks. Price, each	**1.50**
No. 63A1778	Medium Rock End Doors, right or left hand. Price, each	**1.20**
No. 63A1111	Heavy Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1112	Heavy Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1114	Shallow Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1115	Shallow Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1118	Tool Edge Rock Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1119	Tool Edge Rock Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1780	Tool Edge End Doors, right or left hand. Price, each	**1.20**
No. 63A1122	Panel Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1123	Panel Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1782	Panel Face End Doors, right or left hand. Price, each	**1.20**
No. 63A1125	Tool Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1126	Tool Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1784	Tool End Doors, right or left hand. Price, each	**1.20**
No. 63A1137	Face Plates for making imitation pressed brick, whole blocks. Price, each	**1.50**
No. 63A1138	Face Plates for making imitation pressed brick, halves and quarters. Price, each	**1.50**
No. 63A1790	End Doors for making imitation pressed brick design, right or left hand. Price, each	**1.20**
No. 63A1128	Cobblestone Face Plates for whole blocks. Price, each	**1.50**
No. 63A1129	Cobblestone Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1786	Cobblestone End Doors, right or left hand. Price, each	**1.20**
No. 63A1132	Water Table Face Plates to make whole blocks. Price, each	**1.50**
No. 63A1133	Water Table Face Plates to make halves and quarters. Price, each	**1.50**
No. 63A1788	Water Table End Doors, right or left hand. Price, each	**1.20**
No. 63A1140	Ornamental Design Face Plate with whirlwind scroll for making whole blocks. Price, each	**1.50**
No. 63A1141	Ornamental Design Face Plate with whirlwind scroll for making half and quarter blocks. Price, each	**1.50**
No. 63A1792	Ornamental Design End Doors with whirlwind scroll, right or left hand. Price, each	**1.20**
No. 63A1144	Ornamental Face Plate with rope design on face for making whole blocks. Price, each	**1.50**
No. 63A1145	Ornamental Face Plate with rope design on face for making half and quarter blocks. Price, each	**1.50**
No. 63A1794	Ornamental End Doors with rope design, right or left hand. Price, each	**1.20**
No. 63A1151	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each,	**1.50**
No. 63A1152	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each,	**1.50**
No. 63A1153	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each,	**1.50**
No. 63A1154	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each,	**1.50**
No. 63A1155	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each,	**1.50**

NOTE—To make half and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a whole block produce very desirable results.

No. 63A1796	End Doors, right or left hand. Broken Ashler Design. Price, each	**1.20**
No. 63A1750	Pallets for Regular Blocks. Weight, about 13 pounds each. Price, each	**.43**
No. 63A1100	Double End Tamper. Price, each	**.80**

Price List of Attachments and Extras for Making 4-inch Course Blocks on the Improved Buckeye Cement Block Machine, Size 8x12x16 Inches

We can furnish special face plates for the Improved Buckeye Hollow Cement Block Machine, size 8x12x16 inches, for making 4-inch course blocks (4x12x16) in either plain face, rock face, panel face or tool face design. It requires two sets of special end doors and two face plates to make a complete outfit for making 4-inch blocks. You will need one face plate for making whole blocks, 4x8x16 inches, and you should have another face plate of the same design for making halves and quarters, also one pair of core end doors and another pair of end doors to match the face plate. You will require half and quarter blocks, and money spent for face plate to make fractional blocks is well invested and will enable you to produce the very best results.

No. 63A1200 Plain Face Plates for making 4-inch course blocks, size 8x12x16 inches. Makes two 4-inch blocks at a time. Price, each........ $1.50

No. 63A1201 Plain Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each........ 1.50

No. 63A1202 Rock Face Plates for making 4-inch course blocks, size 8x12x16 inches. Makes two 4-inch blocks at a time. Price, each........ 1.50

No. 63A1203 Rock Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each........ 1.50

No. 63A1204 Panel Face Plates for making 4-inch course blocks, size 8x12x16 inches. Makes two 4-inch blocks at a time. Price, each........ 1.50

No. 63A1205 Panel Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each........ 1.50

No. 63A1206 Tool Face Plates for making 4-inch course blocks, size 8x12x16 inches. Makes two 4-inch blocks at a time. Price, each........ 1.50

No. 63A1207 Tool Face Plates for making 4-inch course blocks, for making halves and quarters to match above. Price, each........ 1.50

No. 63A1751 End Doors, Plain Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair........ 1.25

No. 63A1752 End Doors, Rock Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair........ 1.25

No. 63A1753 End Doors, Panel Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair........ 1.25

No. 63A1754 End Doors, Tool Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair........ 1.25

No. 63A1755 Core End Doors (make the cove end on regular blocks) for making 4-inch course blocks. **You will need one pair of this style of end doors with any 4-inch outfit.** Right and left hand. Price, per pair........ 1.25

No. 63A1756 Special Inside Core Pallets, used when making two 4-inch course blocks at one time. Cast iron. Price, each........ .30

These inside or divisional pallets should be used where you have any large number of 4-inch course blocks to make. With the use of these dividing pallets you can work your machine to its greatest capacity.

BUCKEYE MAKES THE BEST BLOCKS USED IN PATERSON.

9 Graham Ave., Paterson, N. J., Dec. 8, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I received your letter inquiring about the Buckeye Cement Block Machine I purchased from you, and in reply will state that I have completed a house with them and have found them very satisfactory. I have exhibited them at different places and the decision was unanimous that they were the richest blocks ever made in Paterson.

As to being damp, I think there is no danger, as the inside of the block is always perfectly dry. All my blocks are mixed with five parts of sand to one part of cement. I think these O. K.

Yours very truly, WM. LUDWIG.

CEMENT BLOCK HOUSE BUILT BY THIS CUSTOMER IS MORE COMFORTABLE THAN HIS FRAME RESIDENCE.

162 Providence St., Waverly, N. Y., Dec. 8, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Yours of recent date at hand. The last of May I purchased a Buckeye Cement Block Machine. Have made about 2,000 blocks on the machine. Have just completed the house. The house is much warmer, drier, and requires much less heat to warm it than the one in which I reside, which is built of wood. The house made of concrete is **not** damp. It is plastered directly on the blocks.

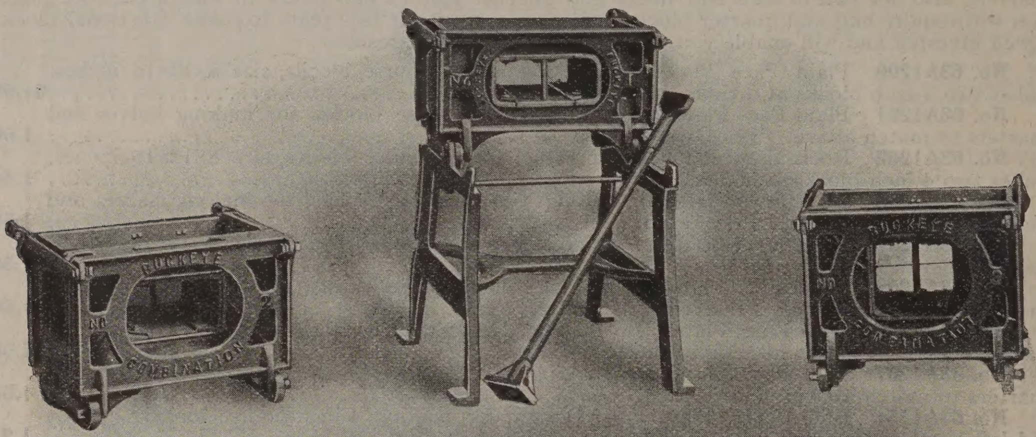
One great advantage of this size of block is that one man can lay more in a day than of the larger blocks which require two men to handle. A mixture of five parts sand to one part cement, sand to be perfectly dry, and two of cement to one of sand for 1-inch face properly mixed, makes a block that will stand anything and practically no dampness can penetrate.

I have found that the drier you can work the mixture, the nicer the block will be. The trouble with most of the work is that not enough cement is used. A number of concrete buildings have been erected in this vicinity within a few years, and with the exception of the first one, I hear no complaint of dampness. The mason I employed claimed these were the best blocks he ever saw.

The machine is perfectly satisfactory and will do as good work as any of the higher priced machines. The porches and some other outside work are not yet complete, being delayed by the cold weather. When finished I will send you a photograph.

Yours truly, IRVING M. CASE.

The Improved Buckeye Combination Hollow Cement Block Machines



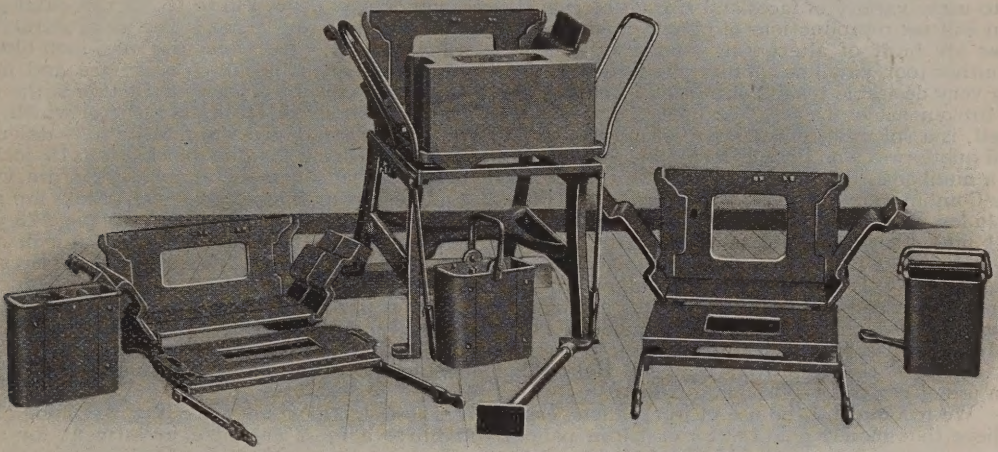
The above illustrations show our Improved Buckeye Hollow Cement Block Machines in three sizes, one complete stand or base, one tamper and three complete moulds or flasks, each one of which is shown fitted with an iron pallet. The center illustration shows the 8x8x16-inch size flask or mould fitted on the stand or base. The 8x10x16-inch is shown to the left, while the 8x12x16-inch is shown to the right

AFTER a most careful study and investigation of a great number of cement block machines, after visiting other large cement block factories and going into this matter thoroughly with carpenters, contractors and builders, we find there is an almost universal demand for 16-inch building blocks. Carpenters and contractors in the larger cities tell us that they will use nothing but a 16-inch block and they tell us that the principal reason is the fact that one man can handle 16-inch blocks either in the block yard or laying them in the wall. This is a direct saving as compared with the cost of doing the same work where larger and heavier blocks are used, necessitating the expense of hiring two or more men to handle the blocks. Another reason advanced by contractors and builders is that architects specify their work so that floor joists, studding, etc., are usually 16 inches from center to center. This is especially desirable in laying joists. With all of our machines we furnish joist block attachments for putting on the end doors to form an opening in each end of the 16-inch blocks to receive 2-inch joists This allows the weight of the joists to rest on the center of the block below, which is supported by the two ends of the next row of blocks.

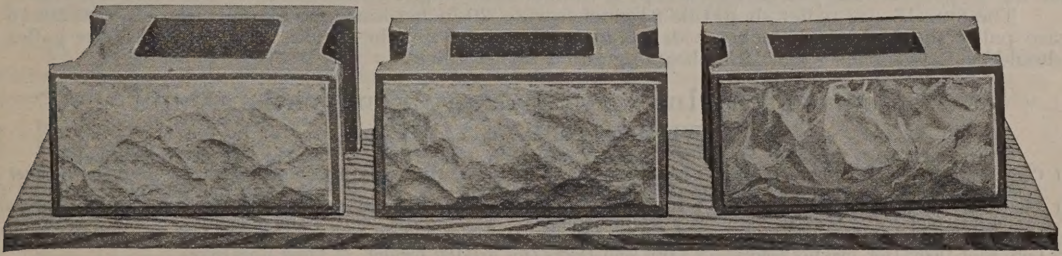
During our investigation of the cement block industry we found that building ordinances of the various cities require walls of certain thickness, according to the size and height of the structure. Many of our machines go into cities and towns where the building ordinances require either 12-inch or 10-inch foundation under an 8-inch wall. With this line of Improved Buckeye Hollow Cement Block Machines, which we make in three sizes, you have a complete outfit that will enable you to build, for instance, a two-story building, using 12-inch blocks for the foundation, 10-inch blocks for the walls of the first story and 8-inch blocks for the walls of the second story.

The Improved Buckeye Cement Block Machine is made in three sizes, namely, 8x8x16 inches, 8x10x16 inches and 8x12x16 inches. It does not require the expenditure of a sum equal to the cost of three separate machines, which is invariably the case with other cement block machine manufacturers. Instead of following the lines of other manufacturers, in offering the Improved Buckeye Hollow Cement Block Machine we follow along the same general lines characterizing our method of selling every kind of merchandise, namely, furnishing our customers with the best goods obtainable at prices that represent manufacturer's cost with a small margin of profit added. With this idea in mind, we have had the Improved Buckeye Hollow Cement Block Machine constructed in such a manner that we eliminate all middlemen's profits, all unnecessary attachments, and to do this we have had many of these parts made interchangeable from one size of the machine to the other. Other manufacturers charge from $3.00 to $5.00 each for face plates. The Buckeye and the Improved Buckeye Hollow Cement Block Machines are made to use the same face plate for all sizes of machines. We use the same base or stand on each size of the Improved Buckeye Hollow Cement Block Machines and they are made to use either wood or iron pallets. We can furnish you with the most complete equipment ever built and at prices way below the price other manufacturers would charge you for a single size of machine.

The illustration shows our Combination Outfit, consisting of one interchangeable base or stand, one complete mould or flask, 8x8x16 inches, one complete mould or flask, 8x10x16 inches, one complete mould or flask, 8x12x16 inches, and each one of these three different sized outfits is complete with one cast iron pallet and one wood pallet. We can furnish either cast iron or wood pallets for either size of machine at prices quoted on pages 69, 73 and 80.



The above illustration shows our Improved Buckeye Combination Hollow Block Machine Outfit fitted up with one base or stand and three flasks or moulds. This illustration shows each one of the three moulds opened up. In this case the 8x10x16-inch machine is setting on the stand and shows a newly made block ready to be carried away. The 8x8x16-inch is shown to the left and the 8x12x16-inch is shown to the right



Rock Face, 8x12x16-inch Buckeye **Rock Face, 8x10x16-inch Buckeye** **Rock Face, 8x8x16-inch Buckeye**

The above illustration shows the three different sizes of hollow cement blocks made on the Improved Buckeye Combination Outfit. The same face plate is used in making either size of blocks, being interchangeable. The length of the blocks is the same and the height of the blocks is the same. The difference is in the thickness of the wall. With this combination outfit you can produce blocks 12 or 10 inches thick for large buildings down to 8-inch blocks used in the construction of residences, cottages and small store buildings.

With each mould or flask we furnish two face plates, one for making whole blocks, 8x8x16 inches, and the other for making halves and quarters, the same design. When shipped out, the 8x8x16-inch size mould or flask is fitted with a plain face plate and accompanied by plate for halves and quarters of the same design. The mould or flask for the 8x10x16-inch size, is fitted with a rock face plate and accompanied by a face plate for making halves and quarters of the same design. The 8x12x16-inch mould or flask is fitted with a panel face plate, and we furnish an extra face plate of the same design for making halves and quarters. This gives you with your outfit six different face plates to enable you to make whole blocks as well as half and quarter blocks of three different designs of faces. With each size of mould or flask, we furnish two core end plates for making regular wall blocks and two end plates of the same design as the face plate, this to enable you to make return corner blocks and also chimney blocks, porch piers or column blocks with face and both ends of the same design. With each flask or mould is furnished a core for the center of the block; also a front and rear core gate and a core gate for the pallet. This enables you to make solid blocks or fractional blocks of any kind. The core gate furnished for the pallet enables you to use the regular pallet, such as is used for making regular building blocks, for making either solid or fractional blocks. Most manufacturers require that you buy a certain number of solid pallets for making solid or fractional blocks, thereby increasing the cost of the outfit. This item of expense is eliminated in all of our machines.

With the Improved Buckeye Hollow Cement Block Combination Outfit you are enabled to meet the requirements of any class of trade; you make blocks suitable for any class of work, and you are able to compete with cement block manufacturers who may have already installed large machines, costing many hundreds of dollars. With the Combination Outfit herein described it is possible for you to compete with any class of work, produce any building block required on any kind of a job of work.

You will note in the list of extras and attachments that can be obtained for the Improved Buckeye Hollow Cement Block Machines that we have an exceedingly large range of faces suitable for turning out a fine assortment of work. An artistic method of treatment in cement construction is to use a variety of faces and sizes of blocks. If you will refer to pages 140 to 152 in this catalogue you will see reproductions of photographs of a number of very fine residences. The more attractive ones are built of alternating courses of 8-inch and 4-inch blocks. Lay a course of 8-inch blocks of either tool, panel or cobblestone face, and then a course of 4-inch blocks of rock face and note the very desirable results obtained. Another good feature in cement block construction is the use of broken ashler faces. We use six different designs of broken ashler faces, each one of which, by itself, is a splendid reproduction of natural stone work. On page 61 you will find we fully describe and quote prices on double face plates with end doors to match for making blocks 4x8x16 inches in a number of different designs. Any of these numbers or designs can be purchased for use with the Combination Outfit above described. These face plates for making 4x8x16-inch blocks are not included with the Combination Outfit, but must be purchased by you as extras. On page 73 you will find description together with catalogue prices of face plates for making 4-inch, 8-inch and 16-inch blocks for the 8x10x16 size machine. On page 81 you will find description and prices of face plates 4x12x16 inches. The above three sizes of flasks or moulds are all made to fit the adjustable stand or base shown in the illustration. If, after purchasing the above outfit, you find your business requires a larger number of blocks, you may purchase one or two additional stands or bases, which will make three complete machines for you.

Each of the Improved Buckeye Hollow Cement Block Machines is so constructed that you can use either the wood or iron pallets.

We recommend the use of iron pallets, especially where you have very much work to do. We believe that money paid out for cast iron pallets will prove a most desirable investment for any person operating a cement block yard or making any large number of blocks. However, for many carpenters and contractors who require only a limited number of blocks for their season's work, the wood pallet will work very satisfactorily, is productive of good results and at a nominal cost. These wood pallets can be made by you after you receive the machine, there being but little labor and the expense is practically the cost of lumber, which in many cases may be almost a complete saving to you because you can use scraps of lumber that might otherwise be of no value elsewhere.

The 8x8x16 size pallet should be 8½ inches wide, 20 inches long and 1 inch thick. The 8x10x16 size pallet should be 10½ inches wide, 18 inches long and 2 inches thick. The 8x12x16 size pallet should be 12½ inches wide, 18 inches long and 2 inches thick.

Contents of the Improved Buckeye Combination Outfit

WITH 1 STAND. 1 TAMPER.

For 8x8x16-inch Blocks

1 Complete Flask or Mould with plain face plate fitted to bottom.
1 Plain Face Plate for making halves and quarters.
2 Plain End Doors (for corners, etc.)
2 Core End Doors (for making regular blocks.)
2 Rock End Doors (for return corners and porch piers.)
2 Panel Doors.
1 Cast Iron Pallet.
1 Wood Pallet.
1 Core Gate for rear wall (for solid blocks.)
1 Core Gate for pallet.
2 Cast Iron Dividers, for halves and quarters.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Cast Iron Core.

For 8x10x16-inch Blocks

1 Complete Flask or Mould with rock face plate fitted to bottom.
1 Rock Face Plate for making halves and quarters.
2 Rock End Doors (for corners, etc.)
2 Core End Doors (for making regular blocks.)
2 Plain End Doors.
2 Panel End Doors (for return corners and porch piers.)
1 Cast Iron Pallet.
1 Wood Pallet.
1 Core Gate for rear wall (for solid blocks.)
1 Core Gate for pallet.
2 Cast Iron Dividers, for halves and quarters.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Cast Iron Core.

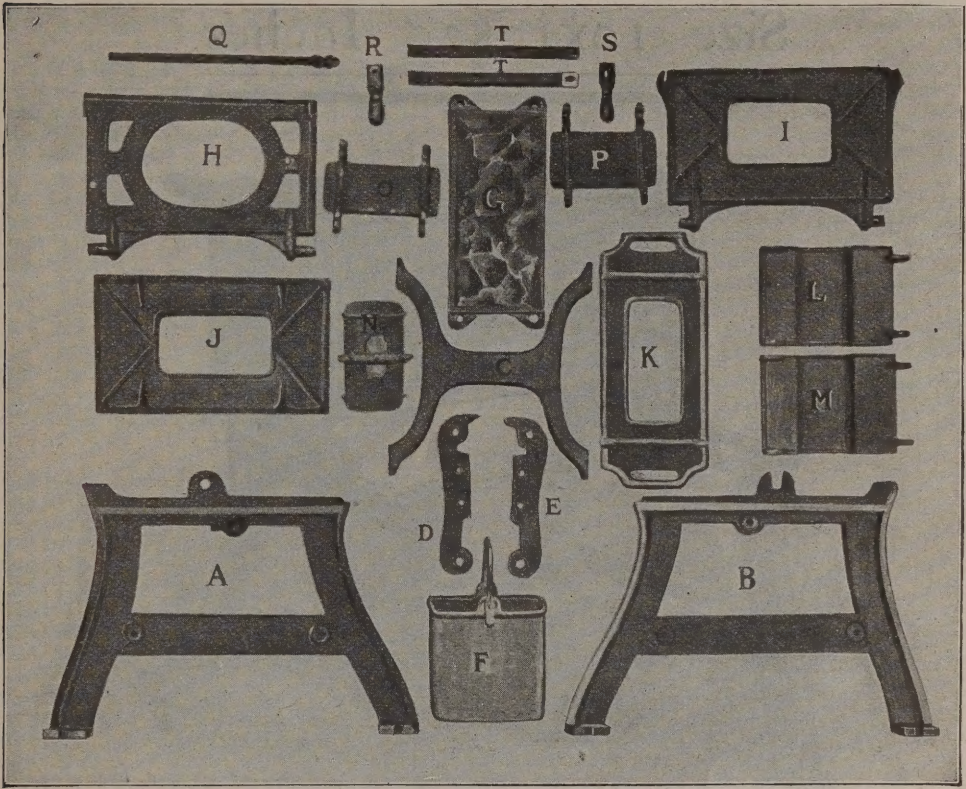
For 8x12x16-inch Blocks

1 Complete Flask or Mould with panel face plate fitted to bottom.
1 Panel Face Plate for making halves and quarters.
2 Panel End Doors (for corners, etc.)
2 Plain End Doors.
2 Core End Doors (for making regular blocks.)
2 Rock End Doors (for return corners and porch piers.)
1 Cast Iron Pallet.
1 Wood Pallet.
1 Core Gate for rear wall (for solid blocks.)
1 Core Gate for pallet.
2 Cast Iron Dividers, for halves and quarters.
1 Right Hand Joist Block Attachment.
1 Left Hand Joist Block Attachment.
1 Cast Iron Core.

No. 63A1798 Improved Buckeye Combination Cement Block Machine Outfit in three sizes, namely, 8x8x16 inches, 8x10x16 inches and 8x12x16 inches, with one complete stand or base and three different moulds or flasks fitted up with six face plates and twenty-four different end doors, making whole blocks and half and quarter blocks in three different designs of faces, namely, plain face, rock face and panel face. Each flask or mould being provided with one cast iron pallet and one wood pallet. Weight of complete outfit, 750 pounds. Price, complete **$85.00**

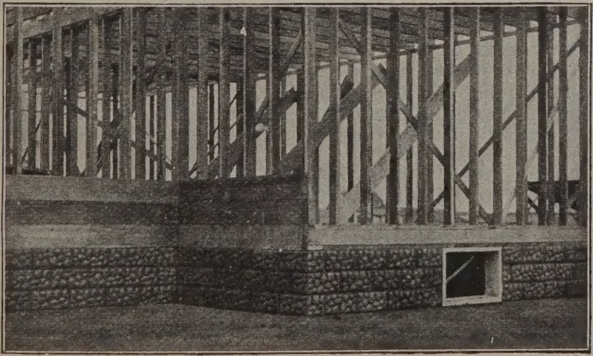
No. 63A1799 Improved Buckeye Combination Cement Block Machine Outfit in three sizes, namely, 8x8x16 inches, 8x10x16 inches and 8x12x16 inches, with one complete stand or base and three different moulds or flasks fitted up with six face plates, making whole blocks and half and quarter blocks in three different designs of faces, namely, plain face, rock face and panel face. Each flask or mould being provided with twenty-five cast iron pallets and one wood pallet. Weight of complete outfit, 1,500 pounds. Price, complete.. **$110.20**

Parts of the Improved Buckeye Cement Block Machine



We reproduce a photograph of each part used in the construction of the Improved Buckeye Hollow Cement Block Machine. In ordering repairs be sure to give the name of the casting as described on this chart and, in addition, do not fail to give us the number and size of your machine.

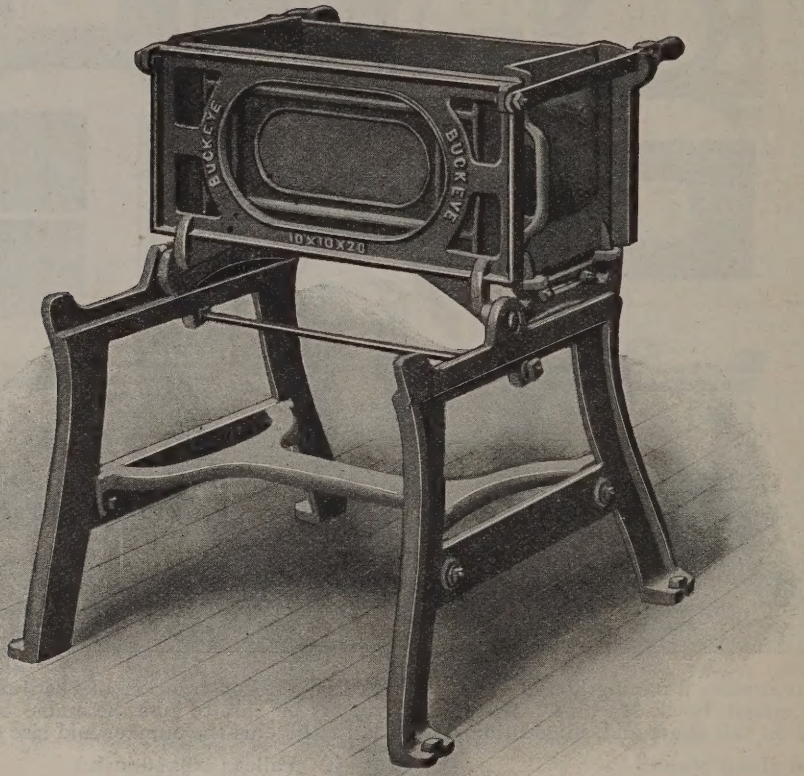
A	Right Hand Stand.
B	Left Hand Stand.
C	Cross Brace for stand.
D	Left Hand Rocker Bed.
E	Right Hand Rocker Bed.
F	Cast Iron Core.
G	Face Plate (8x8x16-inch.)
H	Front Frame of mould.
I	Back Frame of mould.
J	Pallet (10 and 12-inch.)
K	Pallet (8x8x16-inch.)
L	Right Hand End Door.
M	Left Hand End Door.
N	Core Gate Back Wall.
O	Core Gate for pallet (8x8x16-inch.)
P	Core Gate for pallet (10 and 12-inch.)
Q	Cross Brace Rod.
R	Left Hand Handle for lock.
S	Right Hand Handle for lock.
T	Steel Bar for lock.



A Buckeye Cement Block Foundation

We reproduce herewith a photograph sent us by a customer at Fredericktown, Ohio, who purchased a Buckeye Hollow Cement Block Machine from us and has just finished foundation made entirely of blocks with cobblestone face effect. This makes a novel foundation, one that is somewhat out of the ordinary line of work and thereby produces a pleasing effect.

The Buckeye Cement Block Machine
Size 10x10x20 Inches



The Above Illustration Shows the Buckeye Hollow Cement Block Machine, Size 10x10x20 Inches, Fitted with Iron Pallet and Ready to Begin Operation.

We have had an occasional call for a cement block machine to make 20-inch blocks and have built a Buckeye Cement Block Machine to make blocks with 9¾-inch by 19¾-inch face and 9¾ inches thick to lay in a wall 10x10x20 inches. This machine will make either solid or hollow blocks, as wanted, and can be furnished with the same style faces and parts as used on any other size of our line of Buckeye Cement Block Machines. A hollow cement block made on this machine weighs about 95 pounds when properly cured and seasoned. This size of block is preferred by some contractors and builders and some of our customers write us that it can be made and handled by one man and laid in the wall by one man, although it is pretty heavy for one man to handle with very much speed. The machine is exactly like the regular Buckeye Machine, described on preceding pages, differing only in size and weight. Weight of complete outfit, as described below, about 600 pounds With the 10x10x20 size Buckeye Cement Block Machine we furnish the following outfit:

1 Face Plate for making whole blocks.
1 Face Plate of the same design for making half and quarter blocks.
2 Core Ends.
1 End to match the face for return corners.
1 End to match the face for porch piers.
1 Core Gate for rear wall.
1 Core Gate for front wall.
1 Core Gate for pallets for chimney, solid and fractional blocks.
1 Dividing Plate for making half blocks.
1 Dividing Plate for making quarter blocks.
1 Left Hand Joist Block Attachment.
1 Right Hand Joist Block Attachment.
1 Striker.
1 Double End Tamper
1 Standard Core.
25 Cast Iron Pallets.

Price List of Buckeye Hollow Cement Block Machine, Size 10x10x20 Inches

No. 63A1901 Buckeye Hollow Cement Block Machine, size 10x10x20 inches, with regular outfit, Plain Face Design, for making whole blocks and halves and quarters, with 25 cast iron pallets. Price........ **$33.75**

No. 63A1902 Buckeye Hollow Cement Block Machine, size 10x10x20 inches, with regular outfit, Rock Face Design, for making whole blocks and halves and quarters, with 25 cast iron pallets. Price........ **33.75**

No. 63A1903 Buckeye Hollow Cement Block Machine, size 10x10x20 inches, with regular outfit, Panel Face Design, for making whole blocks and halves and quarters, with 25 cast iron pallets. Price........ **33.75**

No. 63A1904 Buckeye Hollow Cement Block Machine, size 10x10x20 inches, with regular outfit, Tool Face Design, for making whole blocks and halves and quarters, with 25 cast iron pallets. Price........ **33.75**

No. 63A1905 Buckeye Hollow Cement Block Machine, size 10x10x20 inches, with regular outfit, Cobblestone Face Design, for making whole blocks and halves and quarters, with 25 cast iron pallets. Price........ **33.75**

No. 63A1906 Buckeye Hollow Cement Block Machine, size 10x10x20 inches, with regular outfit, Broken Ashler Design (any style), for making whole blocks and halves and quarters, with 25 cast iron pallets. Price........ **33.75**

Price List of Attachments for Buckeye Hollow Cement Block Machine to Make Blocks 10x10x20 Inches

No. 63A1910	Plain Face Plates for whole blocks. Weight, 30 pounds. Price, each	**$2.25**
No. 63A1911	Plain Face Plates for making halves and quarters. Weight, 30 pounds. Each	**2.25**
No. 63A1931	Plain End Doors, right or left hand. Price, each	**1.15**
No. 63A1912	Rock Face Plates for whole blocks. Price, each	**2.25**
No. 63A1913	Rock Face Plates for making halves and quarters. Price, each	**2.25**
No. 63A1932	Rock End Doors, right or left hand. Price, each	**1.15**
No. 63A1914	Panel Face Plates for whole blocks. Price, each	**2.25**
No. 63A1915	Panel Face Plates for making halves and quarters. Price, each	**2.25**
No. 63A1933	Panel End Doors, right or left hand. Price, each	**1.15**
No. 63A1916	Cobblestone Face Plates for whole blocks. Price, each	**2.25**
No. 63A1917	Cobblestone Face Plates for making halves and quarters. Price, each	**2.25**
No. 63A1934	Cobblestone End Doors, right or left hand. Price, each	**1.15**
No. 63A1918	Tool Edge Rock Face Plates for whole blocks. Price, each	**2.25**
No. 63A1919	Tool Edge Rock Face Plates for making halves and quarters. Price, each	**2.25**
No. 63A1935	Tool Edge Rock End Doors, right or left hand. Price, each	**1.15**
No. 63A1920	Broken Ashler Face Plates for whole blocks. Price, each	**2.25**

NOTE.—To make halves and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a broken ashler whole block, produces very desirable results.

No. 63A1936	Broken Ashler End Doors, right or left hand. Price, each	**1.15**
No. 63A1900	Cast Iron Pallets. Size, 10x10x20 inches. Weight, 15 pounds. Price, each	**.43**
No. 63A1100	Double End Tamper. Price, each	**.80**

Bay Window Attachments for Buckeye Cement Block Machine, Size 10x10x20 Inches

We can furnish our adjustable bay window angle plate and attachments, which consist of a face plate with an adjustable angle attachment fitted to one end and two special end doors for making any degree of angle blocks in the following designs of face plates and prices.

No. 63A1926	Set of Complete Bay Window Attachments, Plain Face Design. Price	**$6.00**
No. 63A1927	Set of Complete Bay Window Attachments, Rock Face Design. Price	**6.00**
No. 63A1928	Set of Complete Bay Window Attachments, Panel Face Design. Price	**6.00**
No. 63A1929	Set of Complete Bay Window Attachments, Cobblestone Face Design. Price	**6.00**
No. 63A1930	Set of Complete Bay Window Attachments, Tool Edge Rock Face Design. Price	**6.00**

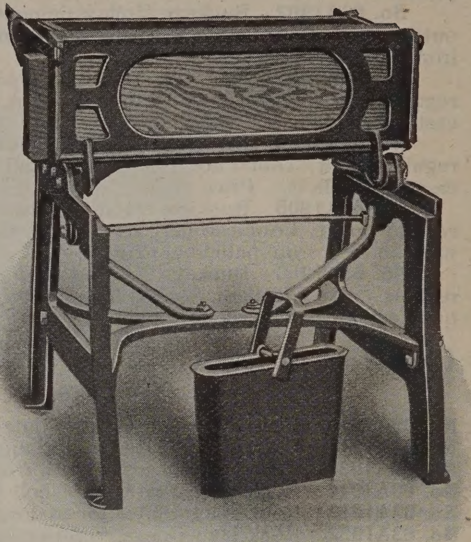
Attachments for Making Circle Blocks on the Buckeye Cement Block Machine, Size 10x10x20 Inches

We can furnish a radius or circle face plate in a number of different designs for making circle blocks. With this face plate are furnished two special end doors to complete the set of attachments. We can furnish these circle plates to make either an 8-foot, 10-foot or 12-foot circle for bay windows, etc. It requires a different set of attachments to make the different angles. We can furnish these circle plate attachments in the following designs and at the prices printed below:

No. 63A1940	Set of Complete Attachments for making 8-foot circle blocks, Plain Face Design. Price, complete	**$6.00**
No. 63A1941	Set of Complete Attachments for making 10-foot circle blocks, Plain Face Design. Price, complete	**6.00**
No. 63A1942	Set of Complete Attachments for making 12-foot circle blocks, Plain Face Design. Price, complete	**6.00**
No. 63A1943	Set of Complete Attachments for making 8-foot circle blocks, Rock Face Design. Price, complete	**6.00**
No. 63A1944	Set of Complete Attachments for making 10-foot circle blocks, Rock Face Design. Price, complete	**6.00**
No. 63A1945	Set of Complete Attachments for making 12-foot circle blocks, Rock Face Design. Price, complete	**6.00**

At the above prices we deliver our line of Buckeye Cement Block Machines and extra parts as shown on this page, carefully packed for shipment on board cars at our factory in Central Ohio, from which point the purchaser pays the freight.

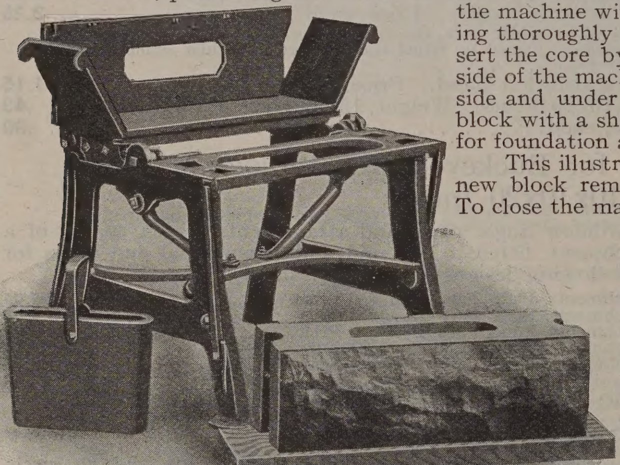
The Ohio Cement Block Machine



THE Ohio Hollow Cement Block Machine is a face down machine with one core that makes a hollow cement block 8x8x24 inches. By using core gates and dispensing with the core you can make a solid block. It is a good all around, first class Cement Block Machine, built heavy enough to stand hard usage and sold at a price within the reach of every carpenter, contractor and builder, for it will pay for itself in a few days, or in making the foundation for one job of work.

We have arranged this machine so that either iron or wood pallets may be used. Any well seasoned lumber will be suitable for the pallets. We find in some localities that iron pallets are preferred. The price of iron pallets will be 40 cents each. We furnish one cast iron and one wood pallet with the machine. The wood pallets are easily made. Cut a board the necessary length and nail a cleat across each end. The sample wood pallet we send with the machine has three grooves, or slots, sawed lengthwise of the board; this is to prevent the pallet from warping or splitting. This is not necessary unless you are compelled to use lumber that is not thoroughly seasoned, or which is liable to warp. As many of these machines reach the hands of carpenters and contractors, we have specially arranged the machine for wood pallets, as they can oftentimes be made of scrap lumber which otherwise would be wasted.

The above illustration shows the Ohio Hollow Cement Block Machine closed, ready to commence making blocks. Makes a block 7¾x23¾x7¾ inches, which lays, allowing for the mortar joint, 8x8x24 inches in the wall. The hollow core is 11¾ inches long and 2¾ inches wide on the small end, giving a large space for air circulation and insulation. On the standard block there are two core ends, leaving a large space for mortar or air at the end of each block. The face plate is on the bottom, permitting the face to be made of finer material than the balance of the block. Fill the machine with the material up to the core hole, tamping thoroughly in the ends and around the outside. Insert the core by hand, it being placed in from the back side of the machine, tamping thoroughly around the outside and under the core ends. Smooth off the top of the block with a shovel or trowel, and you have a good block for foundation and partition walls.



This illustration shows the Ohio machine with the new block removed and ready to insert another pallet. To close the machine up, first throw the back wall, carrying the face plate and the two end gates into position. Now close the end doors, place the pallet in the machine, throw the hinge gate or front and latch, and the machine is ready to make another block. When using cast iron pallets the core extends clear through the pallet. In using the wood pallet the end of the core fits up against the inside of the pallet. We furnish core gates to be used in the iron pallet and the back wall when making solid blocks or halves and quarters. We have had this machine built extra heavy. Our cast iron pallets are extra heavy and are reinforced with braces on the under side. Some prefer cast iron pallets because they will never warp or wear out.

We can furnish the Ohio Cement Block Machine, size 8x8x24 inches, separate from the Adjustable Sill and Cap Machine and where only the cement block machine is wanted we furnish it mounted on the combination stand or base as shown, and fitted up with the following outfit of parts

1 Face Plate for making whole blocks (8x8x24 inches).
1 Face Plate for making half and quarter blocks.
2 Core End Doors.
1 Right Hand End Door to match face plate for making return corners.
1 Left Hand End Door to match face plate.
2 Core Gates.
2 Dividing Plates for making halves and quarters.
1 Striker.
1 Double End Tamper.
1 Cast Iron Pallet, 8x8x24 inches.
1 Wood Pallet.

Price List of the Ohio Cement Block Machine

No. 63A1826 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with plain face plates and plain ends for making whole blocks, half and quarter blocks, with one wood pallet and one cast iron pallet. Weight, 350 pounds. Price........ **$24.50**

No. 63A1827 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with rock face plates and rock ends for making whole blocks, half and quarter blocks, with one wood pallet and one cast iron pallet. Weight, 350 pounds. Price........ **$24.50**

No. 63A1828 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with panel face plates and panel ends for making whole blocks, half and quarter blocks, with one wood pallet and one cast iron pallet. Weight, 350 pounds. Price........ **$24.50**

No. 63A1829 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with tool face plates and tool ends for making whole blocks, half and quarter blocks, with one wood pallet and one cast iron pallet. Weight, 350 pounds. Price........ **$24.50**

No. 63A1830 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with cobblestone face plates and cobblestone ends for making whole blocks, half and quarter blocks, with one wood pallet and one cast iron pallet. Weight, 350 pounds. Price........ **$24.50**

No. 63A1836 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with plain face plates and plain ends for making whole blocks, half and quarter blocks, with one wood pallet and 25 cast iron pallets. Weight, 550 pounds. Price........ **$36.50**

No. 63A1837 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with rock face plates and rock ends for making whole blocks, half and quarter blocks, with one wood pallet and 25 cast iron pallets. Weight, 550 pounds. Price........ **$36.50**

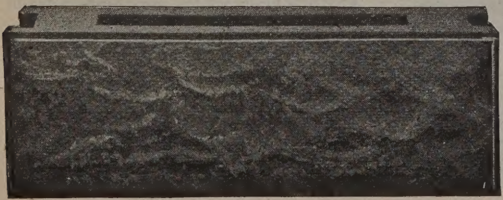
No. 63A1838 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with panel face plates and panel ends for making whole blocks, half and quarter blocks, with one wood pallet and 25 cast iron pallets. Weight, 550 pounds. Price........ **$36.50**

No. 63A1839 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with tool face plates and tool ends for making whole blocks, half and quarter blocks, with one wood pallet and 25 cast iron pallets. Weight, 550 pounds. Price........ **$36.50**

No. 63A1840 The Ohio Cement Block Machine, size 8x8x24 inches, fitted with cobblestone face plates and cobblestone ends for making whole blocks, half and quarter blocks, with one wood pallet and 25 cast iron pallets. Weight, 550 pounds. Price........ **$36.50**

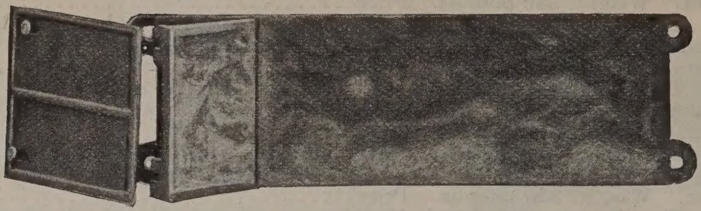
Price List of Attachments for the Ohio Adjustable Cement Sill, Cap and Block Machine, Size 8x8x24 Inches

No. 63A1851	Plain Face Plates to make whole blocks. Price, each	**$2.25**
No. 63A1852	Plain Face Plates to make halves and quarters. Price, each	**2.25**
No. 63A1816	Plain End Doors, right or left hand. Price, each	**.95**
No. 63A1853	Medium Rock Face Plates to make whole blocks. Price, each	**2.25**
No. 63A1854	Medium Rock Face Plates to make halves and quarters. Price, each	**2.25**
No. 63A1855	Rock Face Plates for making three-quarter and one-eighth blocks. Price, each,	**2.25**
No. 63A1817	Medium Rock End Doors, right or left hand. Price, each	**.95**
No. 63A1856	Tool Edge Rock Face Plates to make whole blocks. Price, each	**2.25**
No. 63A1857	Tool Edge Rock Face Plates to make halves and quarters. Price, each	**2.25**
No. 63A1818	Tool Edge Rock Face End Doors, right or left hand. Price, each	**.95**
No. 63A1858	Panel Face Plates to make whole blocks. Price, each	**2.25**
No. 63A1859	Panel Face Plates to make halves and quarters. Price, each	**2.25**
No. 63A1819	Panel Face End Doors, right or left hand. Price, each	**.95**
No. 63A1860	Tool Face Plates to make whole blocks. Price, each	**2.25**
No. 63A1861	Tool Face Plates to make halves and quarters. Price, each	**2.25**
No. 63A1820	Tool End Doors, right or left hand. Price, each	**.95**
No. 63A1862	Cobblestone Face Plates for whole blocks. Price, each	**2.25**
No. 63A1863	Cobblestone Face Plates for halves and quarters. Price, each	**2.25**
No. 63A1821	Cobblestone End Doors, right or left hand. Price, each	**.95**
No. 63A1864	Water Table Face Plates to make whole blocks. Price, each	**2.25**
No. 63A1865	Water Table Face Plates to make halves and quarters. Price, each	**2.25**
No. 63A1822	Water Table End Doors, right or left hand. Price, each	**.95**
No. 63A1811	Wood Pallets, 8x8x24 inches. Price, each	**.20**
No. 63A1812	Cast Iron Pallets, 8x8x24 inches. Price, each	**.50**



The accompanying illustration shows a Rock Face Hollow Cement Block, size 8x8x24 inches, made on the Ohio Cement Block Machine. This illustration shows the proportionate size and length of core used on this machine. This block weighs about 78 pounds.

Bay Window Attachments for Ohio Hollow Cement Block Machines, Size 8x8x24 Inches



Above illustration shows the Face Plate for making Bay Window Blocks on the 8x8x24-inch Ohio Cement Block Machine. This attachment is adjustable to make either an outside or inside angle of any degree.

We can furnish our adjustable bay window angle plate and attachments, which consist of a face plate with an adjustable angle attachment fitted to one end for making any degree of angle blocks, in the following designs of face plates and prices:

No. 63A1871	Set of Complete Bay Window Attachments, Plain Face Design. Price....	**$6.00**
No. 63A1872	Set of Complete Bay Window Attachments, Rock Face Design. Price....	**6.00**
No. 63A1873	Set of Complete Bay Window Attachments, Panel Face Design. Price....	**6.00**
No. 63A1874	Set of Complete Bay Window Attachments, Cobblestone Face Design. Price	**6.00**
No. 63A1875	Set of Complete Bay Window Attachments, Tool Face Design. Price....	**6.00**

Attachments for Making Circle Blocks on the Ohio Cement Block Machines, Size 8x8x24 Inches

We can furnish a radius or circle face plate in a number of different designs for making circle blocks. With this face plate are furnished two special end doors to complete the set of attachments. We can furnish these circle plates to make either an 8-foot, 10-foot or 12-foot radius for bay windows, etc. It requires a different set of attachments to make the different circles. We can furnish these circle plate attachments in the following designs and at the prices printed below:

No. 63A1845 Set of Complete Attachments for making 8-foot radius blocks. Plain Face Design. Price, complete.......... **$6.00**

No. 63A1846 Set of Complete Attachments for making 10-foot radius blocks. Plain Face Design. Price, complete.......... **6.00**

No. 63A1847 Set of Complete Attachments for making 12-foot radius blocks. Plain Face Design. Price, complete.......... **6.00**

No. 63A1848 Set of Complete Attachments for making 8-foot radius blocks. Rock Face Design. Price, complete.......... **6.00**

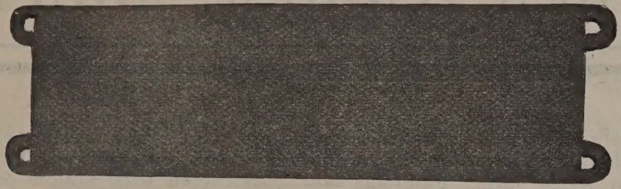
No. 63A1849 Set of Complete Attachments for making 10-foot radius blocks. Rock Face Design. Price, complete.......... **6.00**

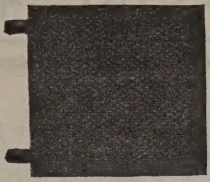
No. 63A1850 Set of Complete Attachments for making 12-foot radius blocks. Rock Face Design. Price, complete.......... **6.00**

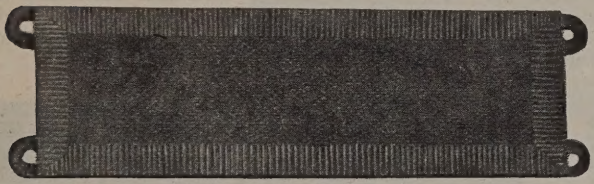
An Up to Date Illinois Cement Block Yard

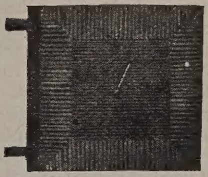
This illustration was sent us last fall by one of our customers in Illinois who is operating two of our X-L-ALL Hollow Cement Block Machines, one of which makes blocks 8x8x16 and the other 8x10x20. These are two of the most popular sizes, especially in smaller communities where buildings are not more than two stories high. Our X-L-ALL machines are the very highest grade machines handled by us, are uniformly satisfactory in the hands of our customers and any man who invests in one or more of these machines is assured of certain success. There are many of these hollow cement block manufacturing plants scattered throughout the country now, and within the next two or three years practically every town in the country will be using cement blocks in large quantities.

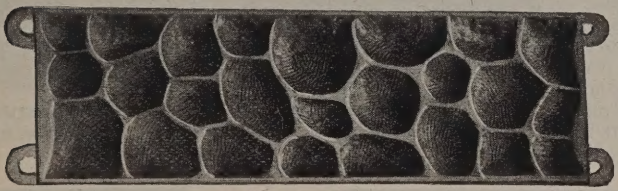
FACE PLATES FOR OHIO BLOCK MACHINE

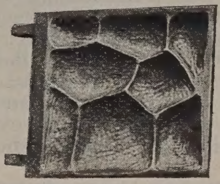

Face Plate for making Plain Blocks on Ohio Cement Block Machine, size 8x8x24 inches

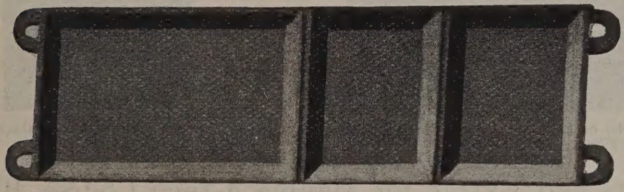

End Door for Plain Block, either Right or Left Hand

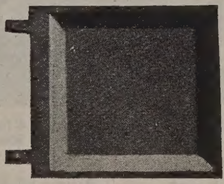

Corrugated Face Plate with Marginal Tool Edge, size 8x8x24 inches

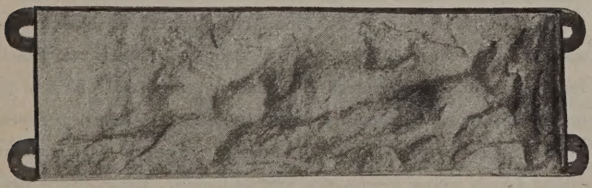

End Door for making Corrugated Ends with Marginal Edge

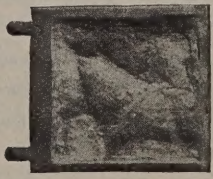

Cobblestone Face Plate for Ohio Cement Block Machine, size 8x8x24 inches

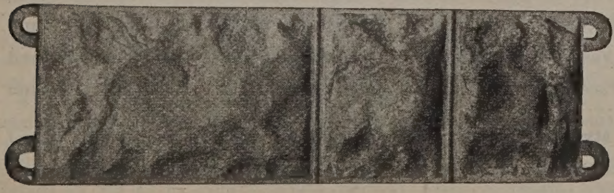

End Door for making Cobblestone Ends


Panel Face Plate for making Half Blocks and Quarter Blocks on Ohio Cement Block Machine, size 8x8x24 inches


End Door for making Panel End Blocks


Medium Rock Face Plate for Ohio Cement Block Machine, size 8x8x24 inches


End Door for Medium Rock Return Corner Blocks

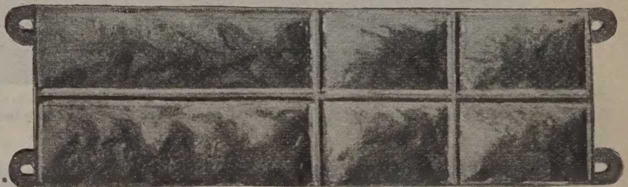

Rock Face Plate for making Half and Quarter Blocks on the Ohio Cement Block Machine, size 8x8x24 inches

The Ohio Cement Block Machine carries an excellent assortment of face plates, as shown on this page.

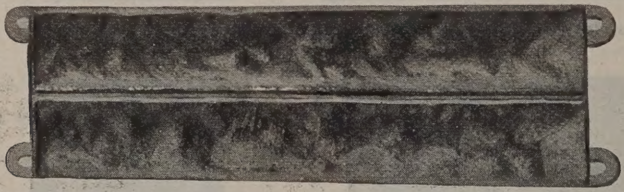
Special 4-Inch Course Blocks

We advise the frequent use of 4-inch course blocks in any wall, no matter what design of face plate is used. Four-inch face blocks break the monotony of a large wall which would otherwise be made of blocks of a uniform size. Many of the larger buildings now constructed with hollow cement building blocks are made with one course of 8-inch blocks, the next course of 4-inch blocks, alternately. For instance, if you are building a wall of 8x8x24-inch rock face building blocks you can add to the appearance of this job very materially by laying one course of 8-inch rock face blocks, then a course of 4-inch plain face, panel face or corrugated face blocks. You will also find that 8-inch panel face, tool face or even plain face blocks, when laid up in the wall in alternate rows or courses with 4-inch rock face blocks, will give you a very artistic wall.

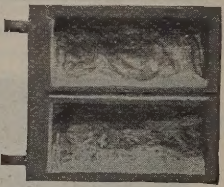
We can furnish special face plates for the Ohio Cement Block Machine for making 4-inch course blocks (4x8x24 inches), in either plain face, rock face, panel face or tool face design. It requires two sets of special end doors and two face plates to make a complete outfit for making 4-inch blocks. You will need one face plate for making whole blocks 4x8x24 inches, and you should have another face plate of the same design for making halves and quarters, also one pair of core end doors and another pair of end doors to match the face plate. You will require half and quarter blocks and money spent for a face plate to make fractional blocks is well invested and will enable you to produce the very best results.



Rock Face Plate for making Half and Quarter Blocks, 4 inches wide, on the Ohio Cement Block Machine. The half block will be 4 inches wide, 8 inches deep and 12 inches long. The quarter block will be 4 inches wide, 8 inches deep and 6 inches long



Rock Face Plate for making 4-inch blocks on the Ohio Cement Block Machine. This makes a Rock Face Block 4x8x24 inches



End Door for making 4-inch Rock Face Return Corner Blocks

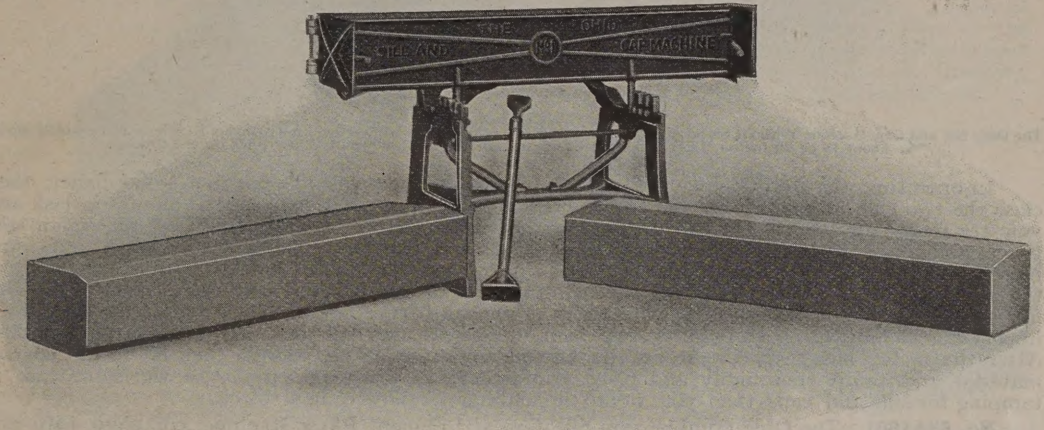
Price List of Attachments and Extras for Making 4-Inch Course Blocks on the Ohio Cement Block Machine, Size 8x8x24 Inches

No. 63A1876 Plain Face Plate for making 4-inch course blocks, size 8x8x24 inches. Makes two 4-inch blocks at a time. Price, each	$2.25
No. 63A1877 Plain Face Plate for making 4-inch course blocks, for making halves and quarters to match above. Price, each	2.25
No. 63A1878 Rock Face Plate for making 4-inch course blocks, size 8x8x24 inches. Makes two 4-inch blocks at a time. Price, each	2.25
No 63A1879 Rock Face Plate for making 4-inch course blocks, for making halves and quarters to match above. Price, each	2.25
No. 63A1880 Panel Face Plate for making 4-inch course blocks, size 8x8x24 inches. Makes two 4-inch blocks at a time. Price, each	2.25
No. 63A1881 Panel Face Plate for making 4-inch course blocks, for making halves and quarters to match above. Price, each	2.25
No. 63A1882 Tool Face Plate for making 4-inch course blocks, size 8x8x24 inches. Makes two 4-inch blocks at a time. Price, each	2.25
No. 63A1883 Tool Face Plate for making 4-inch course blocks, for making halves and quarters to match above. Price, each	2.25
No 63A1891 End Doors, Plain Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair	1.00
No. 63A1892 End Doors, Rock Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair	1.00
No. 63A1893 End Doors, Panel Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair	1.00
No 63A1894 End Doors, Tool Face Design, for making 4-inch course blocks. Right and left hand. Price, per pair	1.00
No 63A1895 Core End Doors (make the core end on regular blocks) for making 4-inch course blocks **You will need one pair of this style of end doors with any 4-inch outfit.** Right and left hand, complete Price, per pair	1.00
No. 63A1896 Special Inside Core Pallets, used when making two 4-inch course blocks at one time. Cast Iron. Price, each	.50

These inside or divisional pallets should be used where you have any large number of 4-inch course blocks to make. With the use of these dividing pallets you can work your machine to its greatest capacity.

The Ohio Adjustable Cement Sill, Cap and Block Machine

THIS IS THE MOST PRACTICAL MACHINE MADE FOR MAKING DOOR AND WINDOW SILLS, CAPS, WATER TABLES, COPINGS, PORCH STEPS AND HOLLOW BUILDING BLOCKS



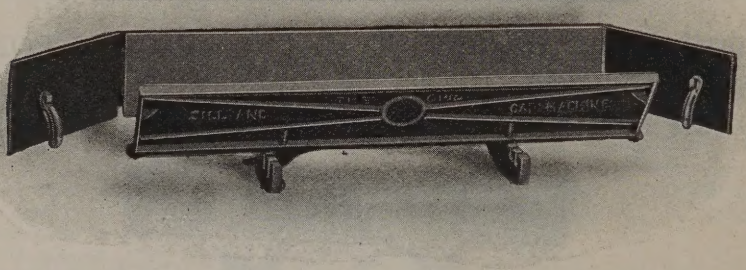
THE Ohio Cement Sill and Cap Machine is a face down machine and makes a window or door sill or cap 48 inches long, 7¾ inches thick and from 10 to 14 inches wide. The machine is adjustable and will make caps or sills of any length up to 48 inches, being easily adjusted to other lengths by blocking up with wood partitions in either end of the mould to make the desired length. The machine is shipped to you with a 10-inch wood pallet 48 inches long. The width of the block is regulated by a series of notches. For the front plate put in a pallet or board of the width that you want to make the sill or cap. The design of the face of the water table can be made in any style wanted by putting in moulding on the pallet and the side of the machine. Water table is faced on the side when made on this machine and the width or angle is regulated by the notches or racks in the rocker arm on the base of the machine and enables you to make almost any shape or angle of water table wanted. The top of a door or window sill can be tapered as wanted by putting in a piece of moulding or nailing a strip of the desired bevel on the wood pallet. The illustration shown on this page shows how easy it is to make any bevel or shape of window sill wanted. The pallets are made of 2-inch pine wood, 48 inches long and of a width corresponding with the range of work wanted. We furnish one wood pallet with the machine to make blocks 10 inches wide and 48 inches long.

The front wall and back wall, together with both end doors, are made from heavy cast iron, with a wide web or flange to strengthen them. The end doors are hinged to the rear wall or back plate of the machine and are locked up square and secured by a toggle lever which is adjustable, thus enabling the lock on the end doors to be changed to the width of the different blocks made on the machine. To remove the block or stone from this machine, unlock the end doors and allow them to swing open or out from the stone, which will release the rear wall or back plate of the machine from the sill or block; then let the front plate of the machine drop forward in the adjustable notches provided for that purpose and you are ready to remove the block.

A door or window cap or sill made on this machine requires the same care in facing and tamping, handling and curing, as that of any other cement block.

Door or window sills or caps should be reinforced in every case. Several of our customers who have been using this machine advise us that they have frequently used old wagon or buggy tires, buggy axles, gas pipe, etc., which are usually of little value, but are a splendid reinforcement for concrete work of this kind. In case you do not have this material you should reinforce these blocks by using double strand or cable wire of about No. 9 or No. 10-gauge. For a 4-foot door or window sill, 10 inches wide and 8 inches thick to secure a good job of work you should use three reinforcements. The size of the sill or cap should determine the amount of reinforcements necessary. We have seen caps and sills where no reinforcements were used, but there is but little strength to a cap or sill of this kind, and it should not be used. A cap or sill 6 or 8 inches wide, 4 feet long, would break of its own weight when turned over on rough ground. **Do not neglect to properly reinforce your caps and sills.**

The Ohio Cement Sill, Cap and Block Machine is Thoroughly Practical, Simple and Easy to Operate and Has No Weak Points



The Ohio Sill and Cap Machine Without Stand or Base. The Machine can be Easily Mounted on a Wooden Bench or Table which should be About 18 or 20 Inches High, Making it Easier to Handle the Block Than When Made on the Ground.

In operating the Ohio Cement Sill and Cap Machine you will first put in a wood pallet, then close the two end doors, drawing the front and rear walls into position; lock the mould or flask and you are ready for work. On other pages of this catalogue we have endeavored to explain the practicability of using face down machines. Sills and caps have two sides exposed and must have two faces; therefore, use regular facing on pallet and for side of block. This always enables the operator to use a better mixture, say half and half, or two parts of sand to one part of cement, for facing the cement work, which will always produce a better looking block and at the same time impervious to moisture. It requires two men to operate this sill and cap machine successfully. After the facing has been spread on the bottom and side of the mould, then fill in the coarser material and tamp thoroughly and place reinforcements where desired. Use the same care in tamping for sills and caps that you would in making a hollow cement block.

No. 63A1801 The Ohio Combination Sill, Cap and Cement Block Machine, complete with one stand, one complete flask or mould for making either hollow or solid building blocks, 8x8x24 inches, fitted with one wood and one cast iron pallet for making whole blocks and halves and quarters, one complete adjustable mould or flask for making sills, caps and lintels. Weight, 400 pounds. Price...$35.75

No. 63A1803 The Ohio Sill and Cap Machine only, with stand. Weight, 245 pounds. Price...**18 75**

No. 63A1805 The Ohio Sill and Cap Machine, without stand. Weight, 155 pounds. Price. **11.25**

No. 63A1810 Wood Pallet, 10 inches wide, 2 inches thick by 48 inches long, for Ohio Sill and Cap Machine. Weight, 15 pounds. Price...**50**

NOTE—See pages 89 and 90 for price of Ohio Cement Block Machine and accessories.

THE X-L-ALL MACHINE THE BEST AMONG SIX OTHER MACHINES IN USE IN KOKOMO.

INDIANA LUMBER CO.

Kokomo, Ind., Dec. 3, 1906

Sears, Roebuck & Co., Chicago, Ill.

Sirs:—In reply to yours of the 26th ult., will have to admit the block machine received by me is the best among six other machines in use here. The X-L-ALL machine is light, durable and speedy. I had one man to make 120 blocks in nine hours. (Did his own tending.)

As to dampness of buildings, your plan of block is best for ventilation. The rest would depend on making a solid face to block so it would be less porous, then ventilate the walls with wall grates. I haven't had any trouble so far about damp houses. I couldn't suggest anything that would make a better block machine. I am so well pleased with the machine that I have been recommending it to others that are contemplating buying machines. I am glad to write you this and hope it will do some good in return for the fair treatment I have received from you.

Yours respectfully, A. C. CARROLL.

THE X-L-ALL IS FULLY UP TO OUR CLAIMS.

Modesto, Calif., Dec. 10, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Yours of the 26th ult. at hand some time since. Have not had time to use the machine much, but have enough to be satisfied that it is fully up to your claims and will make as nice a block as any machine I have seen. When ordering this machine, we did not figure on getting one for rapid work; but as I am using it to build a house for myself, had more in mind of getting a block that would make an absolutely dry wall, and while I have not as yet had the experience of the actual test, do not see how the block can make anything but a perfect dampproof wall. If I were buying a machine to make blocks for the market, I would buy your X-L-ALL Cement Block Machine and may be in the market for same later on. Hoping to be favored with one of the new Cement Block Machinery Catalogues, I remain,

Yours truly, C. J. PARRY.

DID NOT USE THE MACHINE, BUT SOLD IT AT A PROFIT OF $10.00.

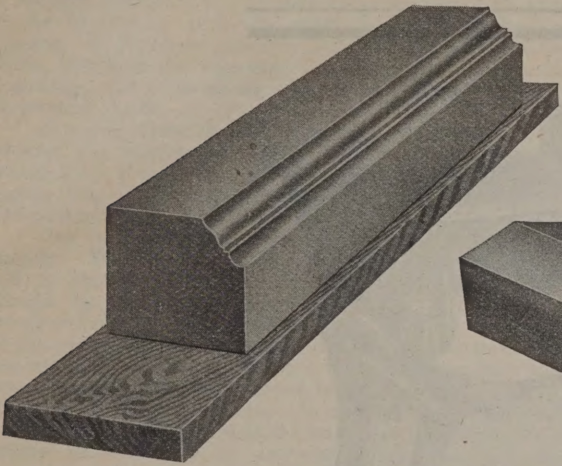
Carterville, Mo., Dec. 18 1906.

Sears, Roebuck & Co., Chicago, Ill.

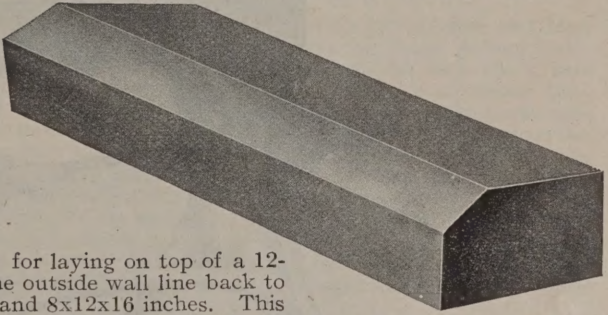
Gentlemen:—On October 4th you shipped me your X-L-ALL Cement Block Machine and asked me to let you know how I liked it. I think it all O. K., but I never used it myself, as I sold it for $10.00 more than it cost, just a few days after I got it. I expect to order another next spring. Yours truly, L. C. HIBBS.

SILLS, CAPS AND LINTELS

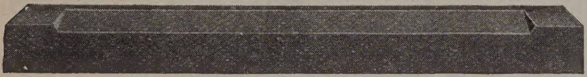
Made of Concrete on the Ohio Adjustable Sill, Cap and Block Machine



This illustration shows a water table made on the Ohio Adjustable Sill and Cap Machine, 8 inches high or thick and 10 inches wide, tapered to reduce the wall from 10 inches to 8 inches. The bevel on this particular block was made by inserting a piece of crown moulding in a lower corner of the mould or flask. Any design or bevel can be put on the concrete block by the operator inserting the style of moulding or blocking desired.

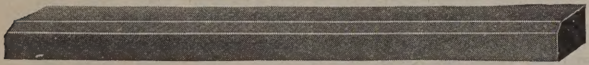


This illustration shows a water table for laying on top of a 12-inch foundation, which tapers or carries the outside wall line back to 10 inches, for using blocks, size 8x10x16 and 8x12x16 inches. This water table is made on the Ohio Adjustable Sill and Cap Machine, and can be made in any width up to and including 14 inches, and any length up to 48 inches. Any size of door sill from 10 to 14 inches in width and 8 inches high or thick and up to 48 inches in length is made the same way.



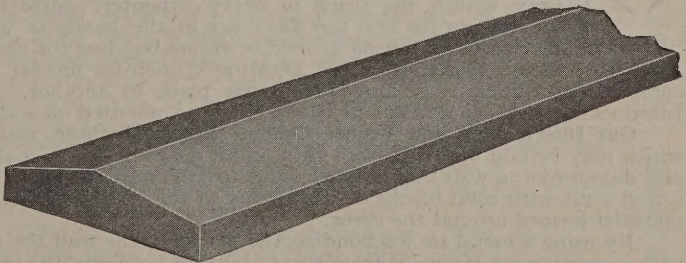
We reproduce a photograph of a window sill made with a bevel which was formed by the use of a piece of moulding of the desired shape and length inserted in the bottom of the mould box or flask. This bevel can be made of any width or depth and any length desired.

This illustration shows a window sill or cap made on the Ohio Adjustable Sill and Cap Machine. The face of this block has been corrugated with a cement user's tool designed for corrugating sidewalks and for other cement work.

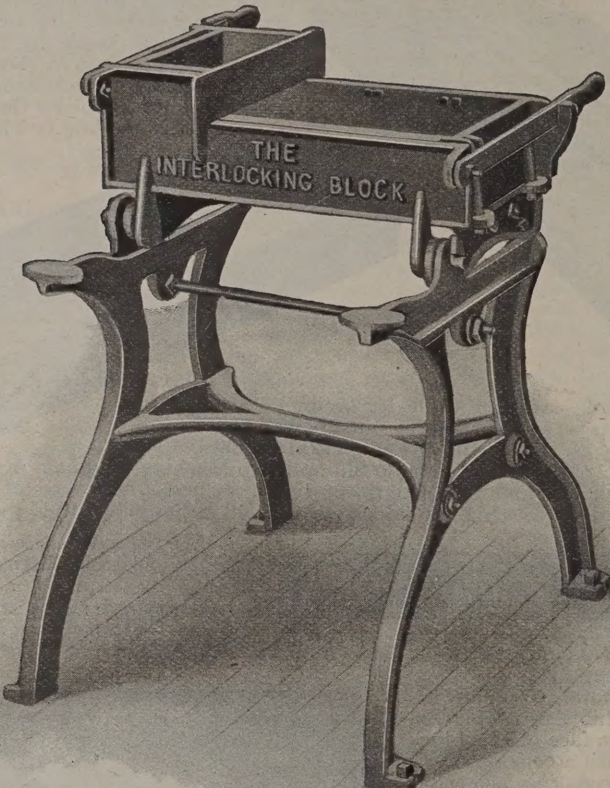


This illustration shows a cement porch rail designed to be used on the top of porch balusters or blocks. This can be made with either one or both sides with either a bevel or round corner as desired. These can be made in lengths to suit the width of the porch. By the use of fillers made of wood block, a large variety of shapes and styles of blocks can be made from the Ohio Adjustable Sill and Cap Machine.

This illustration shows a very handsome design of porch rail made of concrete. This porch rail was made to be placed on the top of 8x8x16-inch building blocks. This rail is 12 inches wide, thus projecting over the porch walls or blocks 2 inches on each side. The top side is tapered or beveled from the center out to the ends. This is easily made in the Ohio Adjustable Sill and Cap Machine and can be made in any width from 4 inches up to 14 inches and in any thickness from 2 inches up to and including 8 inches.



The Interlocking Cement Block Machine



Above Illustration Shows the Front View of the Interlocking Cement Block and Veneer Block Machine, Mounted on a Stand or Base, Closed and Ready for Use

OUR Interlocking and Veneer Cement Block Machine makes a veneered block 4 inches thick, 8 inches wide and 16 inches long on the face and can be furnished with a number of different style faces, which makes a very desirable veneer block machine, sold at a price within the reach of every carpenter, contractor, or, for that matter, it will pay for itself in the first few days' use in the hands of any person wanting to make veneer blocks for veneering a wood or frame building for their own use. The actual size of the face is 7¾x15¾ inches, allowing ¼-inch for mortar joint. The machine is light and compact and can easily be moved from one place to another. The illustration above shows the Interlocking and Veneer Cement Block Machine mounted on a stand or base, ready for work.

Our Interlocking and Veneer Cement Block Machine makes an "L" shaped cement block, which may be laid up in the wall with an air space between, making a wall that is absolutely frost and dampproof, a wall that is impervious to dampness, cooler in summer and warmer in winter than a wall built with solid blocks or with many of the hollow blocks that have a very large amount of material formed around the cores.

By using a metal tie for bonding the blocks in the wall the interlocking blocks may be laid up with a continuous air space from top to bottom between the outer and inner walls. This will be found absolutely moistureproof and will for all time prevent any dampness or frost appearing on the inner walls. These blocks can be so laid that each block interlocks and binds three other blocks, without the use of a metal tie, making a very strong wall. The blocks are light and easy to handle and a block of this style is preferred by many to the regular hollow block.

The illustration of this machine shows the partition plate in position for making an "L" shaped interlocking building wall block. To make a veneered block, leave out the dividing plate and fill and tamp the block the same depth across the entire face or top of the mould. This is easily done and will form a perfect veneered block 4 inches thick. We have had numerous calls for veneered block machines and find that there is an increasing demand for veneering blocks to repair or remodel frame houses. There are also many new houses made with veneering. There are several objects in view in veneering a house with cement blocks or brick. It adds warmth to the house; it reduces the expense of keeping up the house, requires no painting and will last for years; in fact, if the blocks are properly made and laid in the wall, will never again require any expense for keeping up its appearance or lasting qualities. In building a new frame house and veneering outer walls, you save the expense of siding or weatherboarding, expense of labor, putting on this weatherboarding, cost of painting, etc., which is an expensive item when figured out for a period of fifteen or twenty years.

A frame house should be painted once every three or four years to keep up its appearance and protect the weatherboarding. In the course of twenty years you will have paid for painting anywhere from four or five times the cost of veneered blocks. You must continue the expense of painting as long as the frame house stands, while on the other hand the veneered house requires very little repairing.

Our Interlocking and Veneering Cement Block Machine is furnished with twenty-five cast iron pallets. Wood pallets may be used and by many are preferred because you can make pallets yourself, in many instances, from waste lumber. Wood pallets should be ⅞ of an inch thick and should be of thoroughly seasoned wood, properly sawed and dressed, and it is advisable that wood pallets be reinforced by some method; but many persons use a groove or slot in the under side of the pallet, lengthwise with the wood, an inch or inch and a half apart. This sometimes overcomes the tendency to warp and does not materially weaken the efficiency of the wood pallet. We advise the use of iron pallets, because we believe they are best. These will not shrink or warp, as is liable to be the case with wood pallets. You must not use a wood pallet that is warped, because you will ruin your blocks. Blocks should remain on the pallet for about twenty-four hours, and in order to work either machine up to anywhere near its full capacity, you will need at least 200 pallets.

Instructions for mixing the material and operating the machine are furnished each purchaser. We furnish with our Interlocking Cement Block Machine, mounted on a stand as shown in illustration on opposite page, the following outfit:

1 Interlocking Machine complete with stand.
1 Plain Face Plate for making whole blocks.
1 Plain Face Plate for making halves and quarters.
1 Plain Right Hand End Plate.
1 Plain Left Hand End Plate.
1 Panel Face Plate for making whole blocks.
1 Panel Face Plate for making halves and quarters.
1 Panel Right Hand End Plate.
1 Panel Left Hand End Plate.
1 Dividing Plate or "L" Block Attachment.
2 Dividing Plates for making halves and quarters.
1 Double End Tamper.
1 Steel Striker.
25 Cast Iron Pallets

Weight of complete outfit, about 250 pounds.

No. 63A1975 Price of outfit as described above with base or stand $18.60

Extras for Interlocking and Veneer Cement Block Machine

We can furnish the following extras or attachments for making interlocking "L" shaped cement blocks; also for making veneered blocks, as follows:

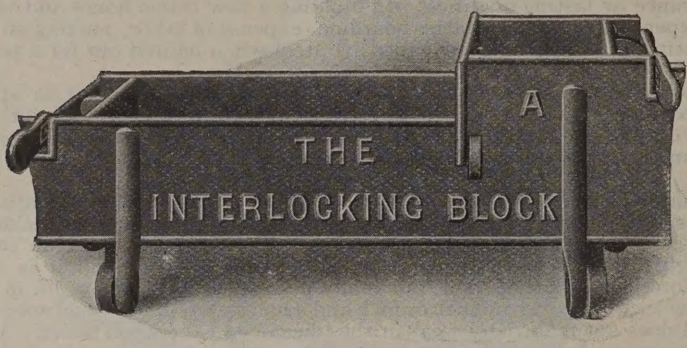
No. 63A1101	Plain Face for whole blocks. Price, each	$1.50
No. 63A1102	Plain face for making halves and quarters. Price, each	1.50
No. 63A1951	Right Hand (small) End Door, Plain Face. Price, each	.40
No. 63A1952	Left Hand (large) End Door, Plain Face. Price, each	.45
No. 63A1105	Rock Face Plates for whole blocks. Price, each	1.50
No. 63A1106	Rock Face Plates for making halves and quarters. Price, each	1.50
No. 63A1953	Right Hand (small) End Door, Rock Face. Price, each	.40
No. 63A1954	Left Hand (large) End Door, Rock Face. Price, each	.45
No. 63A1122	Panel Face Plates for whole blocks. Price, each	1.50
No. 63A1123	Panel Face Plates for making halves and quarters. Price, each	1.50
No. 63A1955	Right Hand (small) End Door, Panel Face. Price, each	.40
No. 63A1956	Left Hand (large) End Door, Panel Face. Price, each	.45
No. 63A1151	Broken Ashler Face Plate, Style A, for making whole blocks. Price, each	1.50
No. 63A1152	Broken Ashler Face Plate, Style B, for making whole blocks. Price, each	1.50
No. 63A1153	Broken Ashler Face Plate, Style C, for making whole blocks. Price, each	1.50
No. 63A1154	Broken Ashler Face Plate, Style D, for making whole blocks. Price, each	1.50
No. 63A1155	Broken Ashler Face Plate, Style E, for making whole blocks. Price, each	1.50

NOTE—To make halves and quarter blocks for broken ashler work, use regular rock face plate for making halves and quarters. Two quarter blocks (4-inch) placed on either end of a whole block produce very desirable results.

No. 63A1957	Right Hand (small) End Door, Broken Ashler Face. Price, each	.40
No. 63A1958	Left Hand (large) End Door, Broken Ashler Face. Price, each	.45
No. 63A1128	Cobblestone Face Plates for whole blocks. Price, each	1.50
No. 63A1129	Cobblestone Face Plates for making halves and quarters. Price, each	1.50
No. 63A1959	Right Hand (small) End Door, Cobblestone Face. Price, each	.40
No. 63A1960	Left Hand (large) End Door, Cobblestone Face. Price, each	.45
No. 63A1118	Tool Edge, Rock Face. Price, each	1.50
No. 63A1970	Cast Iron Pallets. Price, each	.18

Interlocking Cement Block Machine

WITHOUT BASE OR STAND



Above Illustration Shows the Interlocking Cement Block and Veneer Block Machine Set Up and Mounted on Hinges Without Base or Stand

We furnish the Interlocking and Veneered Cement Block Machine without the stand, for making an "L" shaped building block, also a veneered building block, as shown in illustration No. 2 with the following outfit, namely:

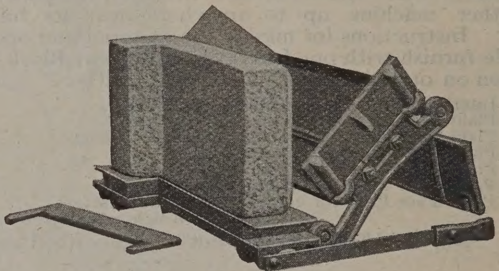


Illustration No. 2

1 Interlocking Machine, complete without stand.
1 Plain Face Plate for making whole blocks.
1 Plain Face Plate for making halves and quarters.
1 Plain Right Hand End Plate.
1 Plain Left Hand End Plate.
1 Panel Face Plate for making whole blocks.
1 Panel Face Plate for making halves and quarters.
1 Panel Right Hand End Plate.
1 Panel Left Hand End Plate.
1 Dividing Plate or "L" Block Attachment.
2 Divisional Dividing Plates.
1 Double End Tamper.
1 Steel Striker.
25 Cast Iron Pallets.

No. 63A1974 Weight of this outfit, about 200 pounds. Price of the complete outfit without base or stand.................................**$14.00**

When packing or shipping the Interlocking Cement Block Machine without stand, we provide two cast iron hinges into which the machine should be set and these hinges bolted down onto a table or platform, thereby making the machine rigid and enabling you to turn it over, to open up and remove the block.

At the prices quoted we deliver our line of Interlocking Cement Block Machines and extra parts as shown, carefully packed for shipment on board cars at our factory in Central Ohio, from which point the purchaser pays the freight.

We make these machines so strong that we do not anticipate there will be any demand for repairs, but if any part should be broken accidentally or otherwise, we can at all times furnish repairs for any machine that may be purchased from us.

Sears, Roebuck & Co., Chicago, Ill. Wakita, Okla., Jan. 3, 1907.

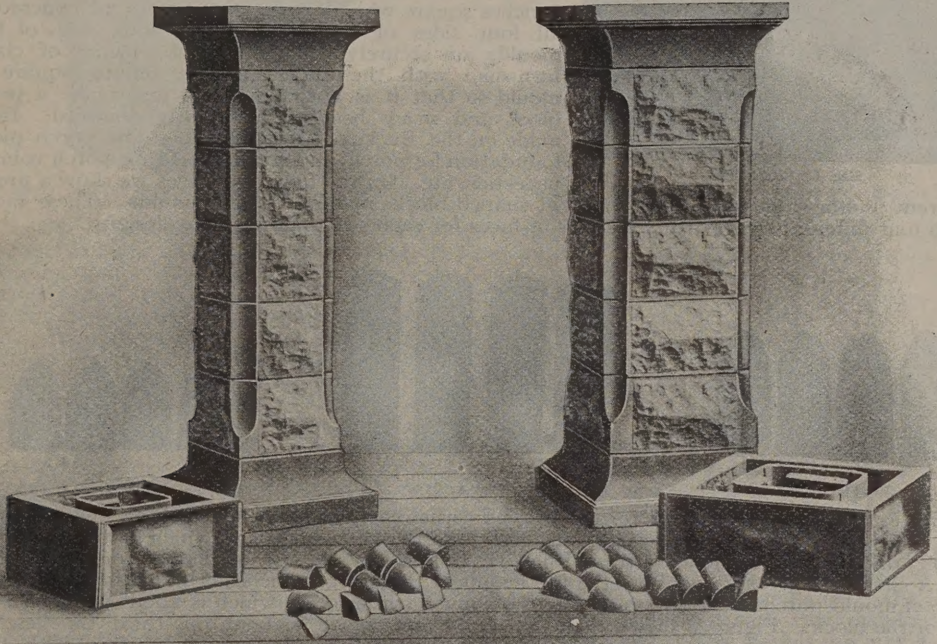
Gentlemen:—I bought an Interlocking Cement Block Machine from you last summer and I want to say that I am a farmer and am not engaged in the cement block manufacturing business. Building material is so high that it is out of reach. Lumber is very high in price. I wanted to build a house and barn, so I sent to you and bought your Interlocking Block Machine and I have built my house and will say that it is over one-half cheaper than lumber, and I am well pleased with the machine and am still better pleased with the house. We did all of the work ourselves. My house is a beauty. It is made of rock face blocks.

I will make blocks this spring for my new barn. My house is plastered directly on the cement blocks. One inch of good facing material made from half cement and half sand, spread evenly on the face plate will insure dry walls, I think, in any climate. It will certainly keep dry walls in this country.

I like my Interlocking Machine much better than any other I have seen. Please send me your Cement Block Machine Catalogue as I have neighbors who are very much interested and who will do the same thing as I have done, that is, buy a machine and build their own houses and barns. Yours truly,

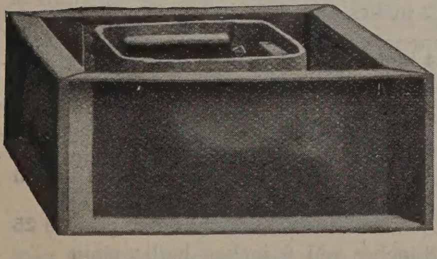
E. FOWLER.

The Buckeye Porch and Chimney Block Moulds and Attachments



THE above illustration shows two pedestals or porch piers made on our Buckeye Porch and Chimney Moulds. These moulds are made in five sizes. The right hand pedestal shown above is made from blocks 8 inches high and 14 inches square. The one shown to the left is made from blocks 8 inches high and 12 inches square. The moulds for making the blocks, 14 inches by 14 inches, are made in two heights, namely, 4 inches and 8 inches. We also make both sizes 12x12 inches square. The bases and caps on both of these pedestals are made on another set of moulds and the large one is 18 inches square and the smaller one 16 inches square. The concaved corners of these pedestals are made by using the corner fillers. One set of three different sizes (four of each size) is furnished with each mould. The moulds can be used without the corner fillers thus making plain corner designs. This makes a very desirable pedestal for porches, etc. This same design of pedestal is frequently used with round columns, either plain or fluted, set on top.

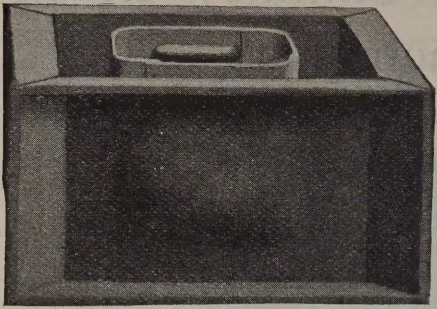
The Buckeye Porch and Chimney Moulds



Size, 16x16x8 inches

The illustration to the left shows one of our Buckeye Moulds with core for making chimney blocks, porch piers and pedestals. These Buckeye Moulds are made in five sizes. The largest one is 18 inches square and 8 inches high. We have several smaller moulds making blocks 16 inches square, 14 inches square and 12 inches square, and 8 inches high and 4 inches high. It requires a different set of moulds for making 4-inch and 8-inch blocks. Each size of mould can be furnished with either plain face or rock face. Each set of moulds is furnished with clamps for holding the four sides in position when making the blocks. These moulds with plain face make good chimney blocks. Every concrete block manufacturer should have two or more sets of these moulds.

The Buckeye Porch and Chimney Moulds—Continued



Size, 12x12x8 inches.

The measurements given are the exact size of the concrete block when finished. The 14-inch and 16-inch mould has a cast iron core 7 inches square which allows 3½ inches of mortar on all four sides of the wall of the block.

The smaller size (12x12 inches) has a cast iron core 6 inches square which allows for 3 inches of concrete on all four sides of the block. The four sides of these moulds are securely held together by means of clamps furnished with the outfit. These clamps square the mould so that it is absolutely true and make a perfect block and may be almost instantly removed. Blocks made on the Buckeye Moulds make a fine porch pier or foundation for porch, and are also used for porch columns, pedestals, etc. On the following pages we show a number of different photographs made from different shaped blocks made on these moulds. These moulds come in four different sizes with two styles of faces for each size, making eight designs.

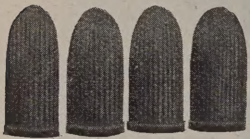


Fig. B

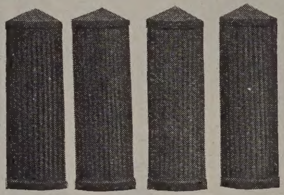


Fig. A

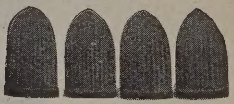


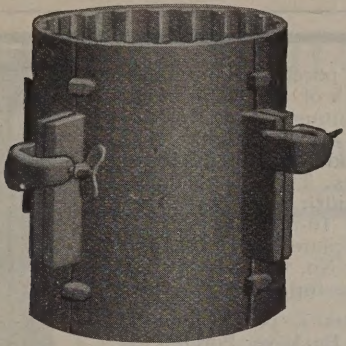
Fig. C

With each Buckeye Mould we furnish convex corner cores or fillers for making special designs of rock face blocks. Note the two pedestals shown on the preceding page, which better describe the range of work that can be done on these Buckeye Moulds by the use of corner cores and fillers. Figure A shows a convex corner core the full height of the block, 4 inches or 8 inches, according to the size of mould purchased. Figure B shows a convex corner core, which is about two-thirds the height of the block. Figure C shows a convex corner core, which is about one-third the height of the block. A full set of these convex corner cores (twelve in all) is included free with every Buckeye Mould. These convex corner cores are especially desirable to use with the rock face moulds.

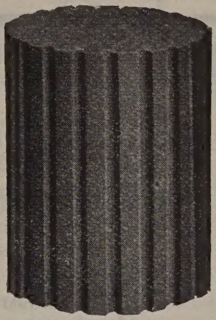
Price List of Buckeye Porch and Chimney Moulds

No. 63A2101	Buckeye Moulds, for making blocks 12x12 inches and 4 inches high, rock face design, complete with cores. Price	$5.25
No. 63A2103	Buckeye Moulds, for making blocks 12x12 inches and 8 inches high, rock face design, complete with cores. Price	6.00
No. 63A2105	Buckeye Moulds, for making blocks 14x14 inches and 4 inches high, rock face design, complete with cores. Price	5.35
No. 63A2107	Buckeye Moulds, for making blocks 14x14 inches and 8 inches high, rock face design, complete with cores. Price	6.75
No. 63A2109	Buckeye Moulds, for making blocks 16x16 inches and 4 inches high, rock face design, complete with cores. Price	5 50
No. 63A2111	Buckeye Moulds, for making blocks 16x16 inches and 8 inches high, rock face design, complete with cores. Price	8.25
No. 63A2113	Buckeye Moulds, for making blocks 12x12 inches and 4 inches high, plain face design, complete with cores. Price	5 25
No. 63A2115	Buckeye Moulds, for making blocks 12x12 inches and 8 inches high, plain face design, complete with cores. Price	6.00
No. 63A2117	Buckeye Moulds, for making blocks 14x14 inches and 4 inches high, plain face design, complete with cores. Price	5.35
No. 63A2119	Buckeye Moulds, for making blocks 14x14 inches and 8 inches high, plain face design, complete with cores. Price	6.75
No. 63A2121	Buckeye Moulds, for making blocks 16x16 inches and 4 inches high, plain face design, complete with cores Price	5.50
No. 63A2123	Buckeye Moulds, for making blocks 16x16 inches and 8 inches high, plain face design, complete with cores. Price	8 25
No. 63A2125	Buckeye Moulds, for making blocks 18x18 inches and 8 inches high, plain face design, complete with cores Price	10 50

The Buckeye Column Moulds



The above illustration shows the Buckeye Fluted Column Mould, 10 inches in diameter



The above illustration shows a section of a 10-inch Fluted Porch Column made on our Buckeye Moulds

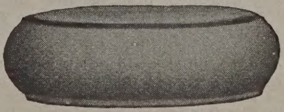
The Buckeye Column Moulds are made in four sections, in either 10 inches or 12 inches diameter, and 12 inches high. These moulds are made to form columns of either plain or fluted design. The top of each section should be made hollow or cone shape, which is easily done by either the use of a trowel or a steel striker from your cement block machine, which can be bent or sprung into a hook shape, so as to have the top of the section taper toward the center of the block, with a fall of probably 1 inch. This allows ample space for cement mortar when building up the column. These columns or sections should be made on the ground with a smooth surface, or can be made on wood pallets and carried away for curing or seasoning, the same as the cement blocks. No cement block or brick yard is complete without a set of these moulds. They will soon pay for themselves in any locality. On the following pages you will find several different designs of columns and porch work that have been made with these moulds. The four-section mould for a fluted round column with core complete, size 10 inches in diameter and 12 inches high, weighs about 65 pounds. The core is 5 inches in diameter at the top and 4 inches in diameter at the bottom, and weighs about 12 pounds.

We also have another mould for making a ring or flange block, either 10 inches or 12 inches in diameter, to be laid between the sections of porch columns. These rings or flanges are made only in plain face The moulds or castings for making these rings or flanges are in two pieces, and make a flange or ring about 4 inches high. These rings can be made either solid or with a core. We do not furnish a core, but any round piece of wood 4, 5 or 6 inches in diameter will answer the purpose where hollow sections are wanted. Making column sections and rings with cores would mean a saving of material, and would not reduce the strength of the block. The moulds for making these rings or flanges are not furnished with the porch column mould, but must be ordered separately, at the price quoted below.

Price List of Buckeye Column Moulds, Etc.

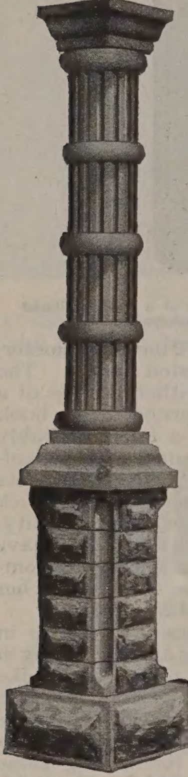
No. 63A2151 Buckeye Column Mould for making fluted columns, 10 inches in diameter, 12 inches high. Price, complete	**$4.50**
No. 63A2153 Buckeye Column Mould for making fluted columns, 12 inches in diameter, 12 inches high. Price, complete	**5.25**
No. 63A2155 Buckeye Column Mould for making plain columns, 10 inches in diameter, 12 inches high. Price, complete	**4.50**
No. 63A2157 Buckeye Column Mould for making plain columns, 12 inches in diameter, 12 inches high. Price, complete	**5.25**
No. 63A2169 Buckeye Moulds for making square base blocks and caps for porch columns, pedestals, etc., tapered with O. G. moulding design. Width of base at widest place is 12 inches square. Price, complete	**7.50**
No. 63A2171 Buckeye Moulds for making square base blocks and caps for porch columns, pedestals, etc., tapered with O. G. moulding design. Width of base at widest place is 14 inches square. Price, complete	**9.00**
No. 63A2173 Buckeye Moulds for making square base blocks and caps for porch columns; pedestals, etc., tapered with O. G. moulding design. Width of base at widest place is 16 inches square. Price, complete	**10.00**
No. 63A2161 Buckeye Mould for making concrete rings or plates used in connection with the Buckeye Column Moulds for making plates 10 inches in diameter, plain face. Price	**3.75**
No. 63A2163 Buckeye Mould for making concrete rings or plates used in connection with the Buckeye Column Moulds for making plates 12 inches in diameter, plain face. Price	**4.50**

Above illustration shows cast iron moulds for making rings or plates used between the sections of porch columns made on Buckeye Moulds



Above illustration shows a sample concrete ring or plate used as a filler or layer between sections of either fluted or plain porch columns made on our Buckeye Moulds

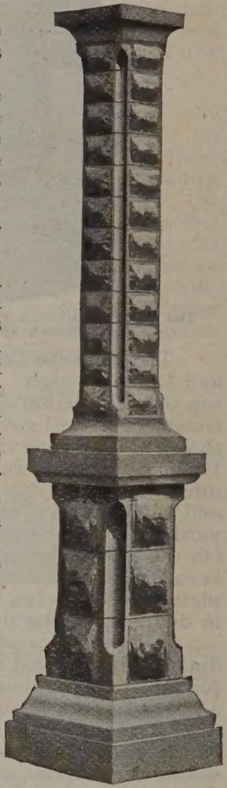
The Buckeye Porch Columns



The illustration to the left shows a porch column made on our Buckeye Moulds. The base block of this column is made on the Buckeye Porch and Chimney Mould, No. 63A2125, and is 18 inches square and 8 inches high. The next section of this porch column is made on our Buckeye Mould, No. 63A2105, size 14x14x4 inches. The intermediate base is made on our No. 63A2163, width 16 inches. The upper part of the column is made with 10-inch fluted sections, alternating with the plain rings or plates, No. 63A2161. The cap of this column is made on our No. 63A2171 Buckeye Mould and is 14 inches square at the top.

The illustration to the right shows a porch column made of square blocks produced on the Buckeye Porch and Chimney Mould. The base of this porch column is 18 inches square. The intermediate base on this job was made in wood moulds. This can easily be done by making a box mould of the size and depth wanted, and where any taper is wanted it can be made by forming regular moulding in the mould box. Wooden moulds can be made at a moderate expense by any carpenter and will produce the same results. The upper section of this column is made on our Buckeye Porch and Chimney Mould, No. 63A2101, size 12x12x4 inches, rock face design. Cap was made in a wood mould made on this job.

Elsewhere in this catalogue we show other styles of porch columns and illustrations of very artistic porch work made of cement blocks manufactured with the Buckeye special moulds. A set of these moulds will prove a very valuable addition to any cement block manufacturing plant because these special sizes and styles of block, so adaptable to a multitude of uses, are just as easily made as the regulation blocks and our Buckeye Moulds give you a completeness of equipment which will enable you to supply almost anything wanted in the cement block line.



CONVINCED CONCRETE CONSTRUCTION WILL SUPERSEDE FRAME.

L. H. HAND & SON,
Breeders of Fine Poultry, Glenwood Springs Farm,
R. F. D., No. 3.

Bloomfield, Ind., Dec. 1, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Your letter of inquiry concerning the Buckeye Cement Block Machine was forwarded to us at the farm, and in reply I will say that the machine gives entire satisfaction. The Buckeye Cement Block Machine is a very light machine, which I consider a great point in its favor, as one can easily afford to move the machine from one place to another, or to a job or contract requiring as many as three hundred blocks. As the block is made face down, we found no difficulty in putting on a half and half sand and cement face, using coarse gravel and sand for all the rest, mixed six to one. We also put on a granite face by using Knoxville mineral red in the sand and cement face.

I believe many people condemn a machine for not making enough blocks. This is a mistake, as the number of blocks turned out depends entirely upon the ability of the foreman to keep the machine turning out blocks **all the time.** We found that two men working in the ordinary manner could only turn out a few more blocks than one good man by himself. We also decided that there should be a mixing floor on each side of the machine, so that one man could do the mixing and cutting concrete all the time without stopping the block machine.

Joseph Joice, a real estate man of Vincennes, is now erecting a ten-room house from plans furnished by myself. As Mr. Joice has built some fifteen or twenty houses in the last year, I presume he investigated the merits of the concrete block very thoroughly before building this house. As for myself, I am convinced that the future will see the frame house as completely superseded by the concrete block building as the log cabin of the past is now superseded by the frame. Yours, **L. H. HAND.**

HAS A READY SALE FOR 3,000 BLOCKS IN THREE MONTHS.

1335 Prairie St., Vincennes, Ind., Dec. 17, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your inquiry as to how the Buckeye Cement Block Machine works which we bought of you some time ago, I will say it gives entire satisfaction, and it is a very rapid machine. I worked the machine myself for thirty days and made on an average about seventy-eight blocks per day of nine hours, besides curing my blocks. I do not see how you can sell the machine for the price you do.

You ask about a house built of these blocks. The blocks that are made on the Buckeye Machine are all right for any building; first, because they are heavy made blocks, which gives them strength; second, they are made face down, and if properly made gives a non-porous face which will not absorb water, therefore you have a very dry wall.

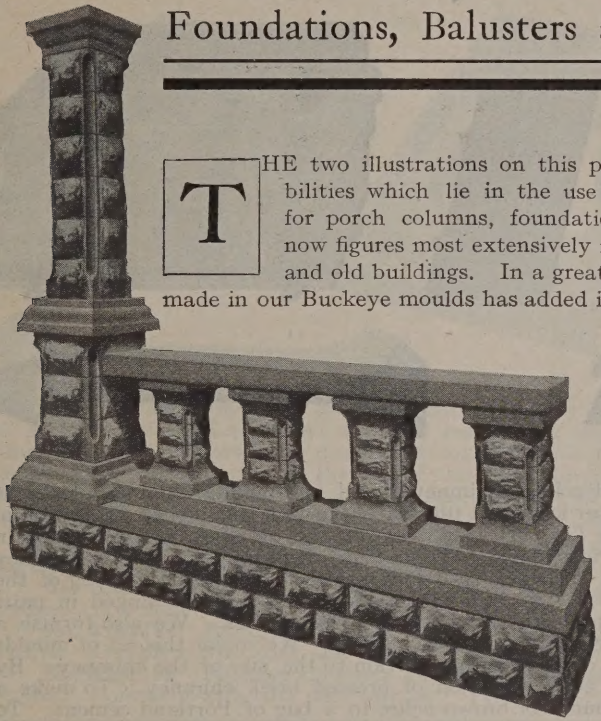
I have been a builder for years and have had quite an amount of experience with buildings. A building made of cement blocks will not make a damp wall if the blocks are made on a face down machine and made with a stronger face, say one-third. Blocks must be thoroughly cured. We plaster to the blocks without any studding, strips or anything.

Can you furnish plates to make blocks 4x8x16 inches and 8x8x16 inches for circular work? The 4x8x16 inches is to be straight. Yours truly, JESSE AND CLARA WILLIAMS.

P. S.—We have made something over 3,000 blocks in three months and have a ready sale for all.

Up To Date Porch Columns

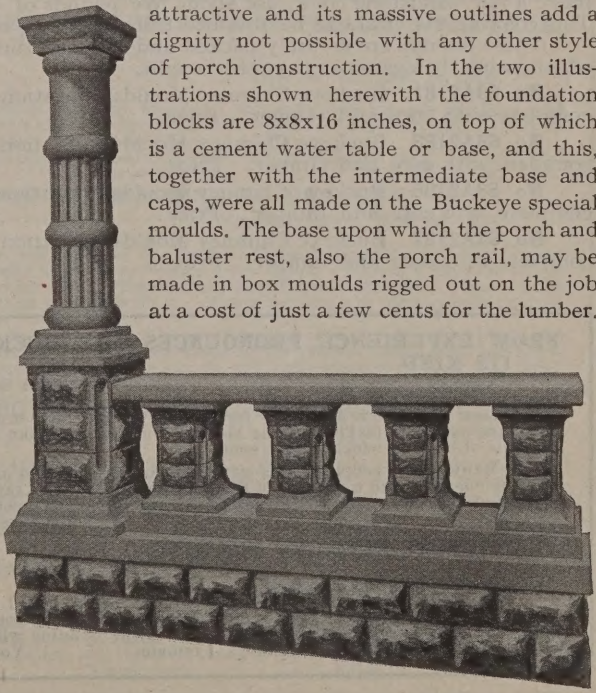
Foundations, Balusters and Porch Rails



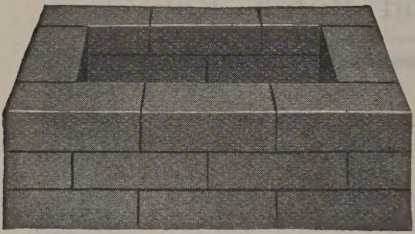
THE two illustrations on this page will give you some idea of the possibilities which lie in the use of cement in the manufacture of blocks for porch columns, foundations, balusters and porch rails. Concrete now figures most extensively in the construction of porches for both new and old buildings. In a great many cases a new porch built with blocks made in our Buckeye moulds has added immensely to the value of an old frame house and yet the investment for the cement material is very modest indeed. Elsewhere in the pages of this special catalogue we illustrate and describe our Buckeye moulds for making special blocks designed for porch work and you will immediately see that the various combinations possible with blocks manufactured in these moulds are almost limitless. Any contractor or builder can well afford the investment represented by the ownership of a set of our special Buckeye moulds, and, indeed, the investment will be returned to him on his first job of consequence.

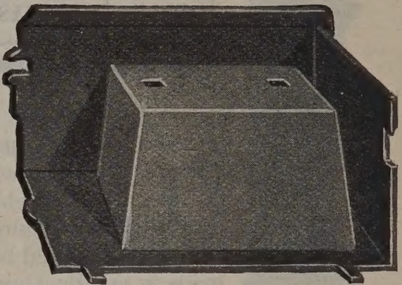
A cement block porch is unusually attractive and its massive outlines add a dignity not possible with any other style of porch construction. In the two illustrations shown herewith the foundation blocks are 8x8x16 inches, on top of which is a cement water table or base, and this, together with the intermediate base and caps, were all made on the Buckeye special moulds. The base upon which the porch and baluster rest, also the porch rail, may be made in box moulds rigged out on the job at a cost of just a few cents for the lumber.

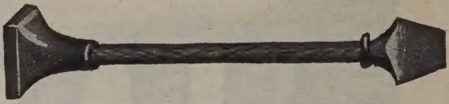
The making of these ornamental blocks is just as easy as the making of the regulation hollow cement blocks, the only difference being that the materials used are manufactured in a little different manner. The foundations are made of the regulation block mixture, but the base and caps and rails are made of the richer mixture of concrete, one part of cement to two parts of screened sand, because these blocks are exposed on three sides and require for their making the same class of material used in making the face of the regulation cement block. Any user of our X-L-ALL or our Buckeye Machines will have no trouble at all in making the very best special blocks, as illustrated herewith, with the Buckeye special moulds. We believe it will be very greatly to your advantage as a manufacturer of cement blocks to add these Buckeye moulds to your equipment because of the great variety of special blocks for a special purpose that you will be able to make and supply to your customers.



Our Buckeye Chimney Moulds







THE above illustrations show our Buckeye Chimney Mould for making chimney blocks to imitate pressed brick. The upper left hand illustration in this group shows a section of a chimney, 16x24 inches. The face or wide way of the chimney is three bricks in width. The chimney is two bricks deep. The outside measurement of this chimney block as shown is 16 inches by 24 inches by 6 inches high. The inside opening of the chimney is 16 inches by 8 inches. This mould consists of four sections hinged in pairs and locked by a cam lever. There are two handles to each flask. We also furnish a cast iron core of the proper size for forming an opening for chimney. We make this set of moulds in three different sizes, and in each set the cores are in proportion to the size of the chimney. By using a facing preparation you can make a good imitation of pressed brick chimney. To make a brown stone color effect, use four or five pounds of brown ochre to a bag of Portland cement. To make a red sandstone color, use about five pounds of oxide of iron to a bag of Portland cement. This coloring material can be obtained from any drug or paint store.

These moulds are securely packed and shipped direct from the factory in Central Ohio, from which point the customer pays the freight.

No. 63A2181 Buckeye Chimney Moulds, imitation pressed brick face, size 16x20 inches, complete with core and tamper. Price	$ 7.50
No. 63A2183 Buckeye Chimney Moulds, imitation pressed brick face, size 16x24 inches, complete with core and tamper. Price	9.00
No. 63A2185 Buckeye Chimney Moulds, imitation pressed brick face, size 20x24 inches, complete with core and tamper Price	10.50
No. 63A2187 Buckeye Chimney Moulds, imitation pressed brick face, size 24x24 inches, complete with core and tamper. Price	12.00

FROM EXPERIENCE PRONOUNCES THE BUCKEYE EQUAL TO ANY MACHINE OF ITS KIND.

701 Seymour St., Cheyenne, Wyo., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—It is a pleasure for me to say that I have ordered a Buckeye Cement Block Machine from you and have used it in making all the blocks for my house. From my own actual experience I find it equal to any machine of its kind which I have seen.

Many of the people of this city have come to me and asked questions concerning the cement blocks and also the machine, and a number of them are sending for this same machine. I found everything just as the company stated. I was more than pleased with the Buckeye Cement Block Machine.

Yours respectfully, PETER LARSON.

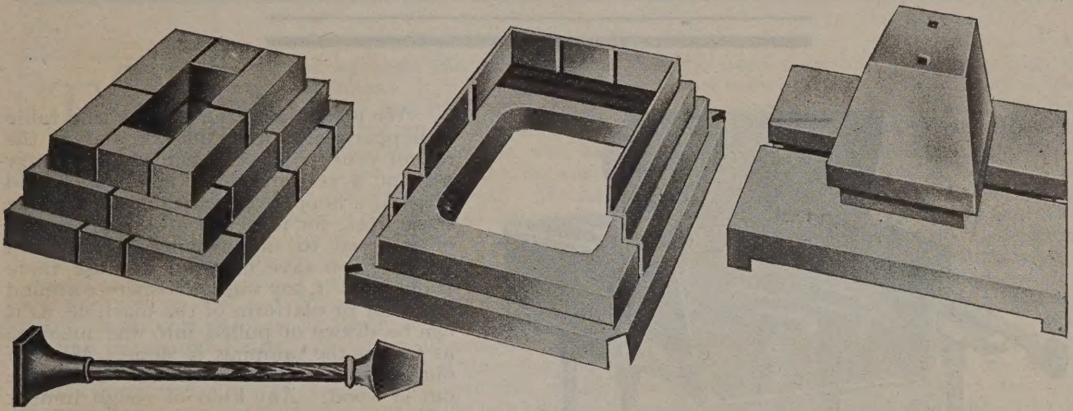
PRONOUNCES BUCKEYE MACHINE O. K.

Charlestown, Ind., Nov. 28, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—I received a letter from you asking how I liked the Buckeye Cement Block Machine. The machine is all O. K. and it makes good blocks. So far, I have only used the blocks for foundation work, but I will make up a lot of blocks and will do the entire building with them next year. I am perfectly satisfied with the Buckeye Cement Block Machine I remain, Yours truly, HARRY HOWELL

Our Buckeye Chimney Top



There is still some call for Ornamental Chimney Tops or Capping for regular brick chimneys. A great many brick chimneys are now made with the wall extending straight up to the top and then capped with artificial stone or a concrete slab the exact size of the chimney and 4 or 5 inches thick with an opening the size of the flue. The outfit which we furnish here is intended to be used with our Buckeye Chimney Moulds, and we can furnish them in the same sizes as quoted on the other page. Outfit consists of hinged mould, lock core and tamper.

No. 63A2190	Buckeye Chimney Top Moulds, imitation pressed brick face. Size, 16x20 inches. Complete with core and tamper. Price	$ 7.50
No. 63A2192	Buckeye Chimney Top Mounds, imitation pressed brick face. Size, 16x24 inches. Complete with core and tamper. Price	9.00
No. 63A2194	Buckeye Chimney Top Moulds, imitation pressed brick face. Size, 20x24 inches. Complete with core and tamper. Price	10.50
No. 63A2196	Buckeye Chimney Top Moulds, imitation pressed brick face. Size, 24x24 inches. Complete with core and tamper. Price	12.00

THIS CUSTOMER USES THREE BUCKEYE MACHINES AND IS PLEASED WITH THEM.

A. S. BRYANT, Contractor and Builder,
Steam and Hot Water Heating.

Berwyn, Md., Dec. 18, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—The three Buckeye Cement Block Machines bought of you some time ago are all that could be expected. Blocks made with them are far better than blocks made with a side face machine, and I think as many blocks can be made with the Buckeye Machine, making one block at a time.

I am building three houses with cement blocks, and when completed will photograph them and send you one of each. Yours respectfully, A. S. BRYANT.

WOULDN'T TRADE THE BUCKEYE FOR ANY MACHINE HE HAS SEEN.

Grayling, Mich., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—In reply to yours of recent date, will say that the Buckeye Cement Block Machine I purchased of you is the most complete machine on the market. I wrote to several firms before I bought a machine to get one that made the face down, as I would have no other kind. Through our friend (your catalogue), I found what I wanted and sent for a machine, and am more than pleased with it. Would not trade it for any higher priced machine that I have seen so far.

It makes a good solid block and is easy to operate. I do a large amount of cement work of all kinds and know a good thing when I see it. I find that most of the block machines on the market today have too much to them. Your machine has less parts and is more simple and can do the same amount of work that other machines will do. Yours very truly, C. W. AMIDON.

THIS CUSTOMER MAKES EVERYTHING NEEDED IN BUILDING A HOUSE OF CEMENT.

Moline, Ill.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I have one of your Buckeye Cement Block Machines. Perhaps you will be interested to know what we make with it. We make water table blocks, joist blocks, jamb blocks, etc., using our own devices to attain these results. We make cap stones, door sills, window sills and belt courses, also. Of course, we cannot make these in the machine on account of the length. We think that we can make almost anything that may be needed to build the entire house in this machine. We are well pleased with it and hope to have another in the spring. Yours, E. J. PICKARD.

THE BUCKEYE MACHINE IS VERY SATISFACTORY.

Linton, Ind., Dec. 2, 1906.

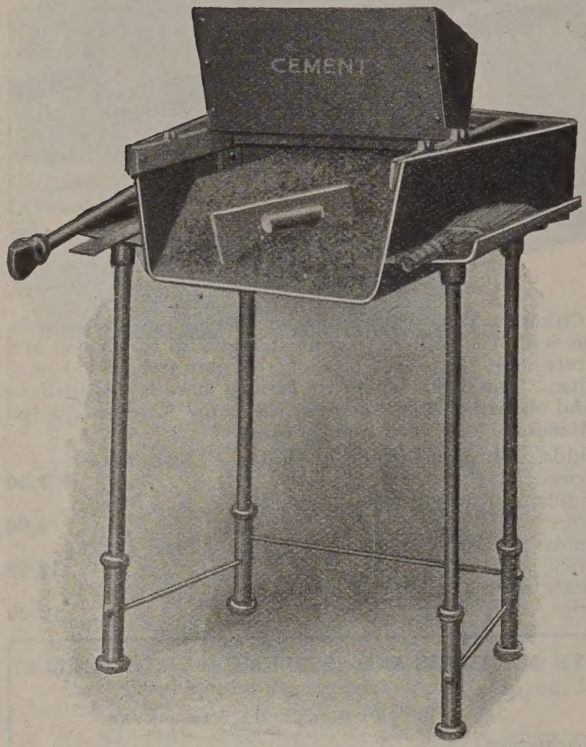
Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I received your letter and wish to say the Buckeye Machine I purchased from you is very satisfactory. I made some blocks on it and it made them all right. I like this machine better than any I have seen. Please send me the price list or catalogue of pallets and different kinds of faces.

Yours truly, EDWARD PAGE.

All Steel Feed Table or Hopper

for Cement Block Machines



We recommend the use of a feed table or hopper placed over the top and to the rear of your cement block machine. Every user of a cement block machine should provide a hopper or feed table built along these lines, for it means a saving to you of material, to say nothing of time and labor. You save material because there is but little if any waste of concrete around the floor or platform of the machine, as it can be drawn or pulled into the machine as fast as the tamping is done. Many of our customers make a similar feed table out of wood. Any kind of rough lumber will answer the purpose and the results are just as beneficial to you. We have had quite a number of inquiries and several orders for a feed table and to meet the demands of such customers we have made this all steel feed table. The hopper or feed table itself is made of sheet steel and is reinforced by cast iron braces and heavy iron bands inside the top of the hopper and is mounted on four legs made of ¾-inch standard iron pipe, with cast iron feet and cross braces at the bottom of the legs. There are two wings or flanges on either side of the feed table, making a handy place to put your whisk broom and trowel, as well as the tamper and stripper. This feed table is provided with a separate box for holding facing material. The main part of the feed table will carry the regular concrete for making the body of the block, while the facing, usually half and half, is placed in the receptacle on top of the hopper and can be tilted over toward the front so as to draw out the material as wanted. You should use a brush or whisk broom around your cement block machine. It helps to keep the face plates and end doors free from concrete and your machine should be kept clean at all times. Use a whisk broom liberally. This hopper or feed table will soon pay for itself.

We ship it knocked down and crated. Weight, about 100 pounds. Customer pays the freight on this feed table from Bradley, Illinois. It cannot be shipped with Buckeye machines.

No. 63A998 All Steel Feed Table or Hopper for cement block machine. Price, each **$5.50**

No. 63A999 All Steel Feed Table or Hopper with cement box as shown in illustration. Price, each. **$7.50**

THE X-L-ALL MAKES A BLOCK NO OTHER MACHINE CAN BEAT.

Sears, Roebuck & Co., Chicago, Ill. Cromwell, Ind., Dec. 5, 1906.

Dear Sirs:—I can say that I am using the X-L-ALL Cement Block Machine and it is all I expected it to be. I have used it one season and am well satisfied. If I were buying another machine, it would be an X-L-ALL Cement Block Machine, for it is easy to operate and makes a block that no other machine can beat.

Yours truly, J. A. GREIDER.

ALL CONTRACTORS AND MASONS ENDORSE HIS MACHINE.

Sears, Roebuck & Co., Chicago, Ill. 23 Madison St., Ashtabula, Ohio.

Gentlemen:—Replying to your letter of inquiry regarding the cement block machine, can gladly say it is giving the best of satisfaction. As I am not a new man in the cement block business, I consider I know a good machine when I see it. There are quite a number of other machines in this town, but all the contractors and masons speak highly of the Buckeye machine. Yours very truly E. E. HOYT.

The Harvard Brick Machines

THIS is the cement age and the manufacture of brick from sand and cement is only in keeping with the times. It is true the manufacture of cement brick is in reality a new industry, yet it is one that has made wonderful strides toward the front within the last few years, and today the contracting and building public, as well as manufacturers of brick, dealers in lumber, in fact everyone who has anything to do with building material, is wide awake to its vast possibilities, because of the cheapness of cement as compared with the cost of other building material. We have sold machines for making cement building blocks for a considerable length of time and during this period have received a great many inquiries from our customers and others, indicating a desire to buy a good cement brick machine. For some time past we have been investigating a number of different makes of cement brick machines with a view of taking up the sale of a good machine for making cement brick. We have found a machine which will do its work well and which at the same time we can sell at a reasonable price, that is, a price based on the cost of material, labor, etc., with a reasonable profit added. Like cement block machines, we find the manufacturers of almost all cement brick machines put more stress or talk on the fact that their particular machine is patented than they do on the good working features of the machines. We have secured a line of cement brick machines which are made by an old and established machine manufacturer, whose reputation for turning out high grade goods is well known among manufacturers, dealers and users of several lines of well known machines. We sell these machines under the name "HARVARD" and on the follow pages give you very complete information concerning this fine machine.

Our inquiries in the past have been for a line of machines ranging from a one man machine with small capacity up to machines used generally in brickyards, by large building contractors, etc. In our line of Harvard Cement Brick Machines we can meet the demands of almost every class of manufacture. The Harvard Cement Brick Machine is sold under a positive guarantee that it will produce a perfect brick and that it will perform its work well and at a minimum expense, and the machine is built along lines embodying mechanical strength, speed and ease of operation, and if you are in the market for a cement brick machine, we solicit your order for either size or style of machine, knowing that we can please you. The Harvard Cement Brick Machine contains, without doubt, more machine work than most any other brick machine on the market. All of the parts of the machine are planed and fitted with automatic gauges, thereby insuring a perfect face. The steel guides or divisions between the brick are made from carefully selected cold rolled steel, planed smoothly and every joint perfectly fitted. The front door and rear wall are machined. The guides or division plates are placed in position and removed by means of gears fitted on the outside ends of the machine away from any danger of being covered or filled by cement or concrete while manufacturing bricks. The guides or division plates are carried to the brick chamber on a shaft of cold rolled steel. Every machine is fitted up, thoroughly examined and inspected before being crated or shipped from the factory.

The Harvard Cement Brick Machine makes both plain and ornamental faces and a variety of shapes. The Harvard machine turns out bricks that are absolutely true and uniform, with sharp corners and perfect edges and equal in appearance to the very best pressed brick, and far more durable than clay brick and less impervious to water. With these machines cement brick can be made at a minimum cost and with a small amount of capital. They are easy to operate and every convenience for handling the brick is taken into consideration, thus enabling a large capacity at a minimum expense.

The Harvard Cement Brick Machine is built in four sizes, namely, 5, 10, 20 and 40-brick.

Cost of Manufacturing Brick

It is hard to figure the cost of cement brick, as the price of material varies in different localities. In many places good sand can be obtained for the cost of hauling. You can figure that it will require about two barrels of good Portland cement and 1¼ yards of sand to make a thousand brick of five parts sand and one part cement. This seems to be a good proportion of mixture, one recommended by many manufacturers. For ordinary brick common sand is productive of best results. For cheap brick to be used in inside walls or for rough construction, sand containing gravel up to the size of a quarter of an inch may safely be used. We would not recommend any gravel that would not pass through a sieve with ¼-inch mesh. Brick of this quality is made by using a proportion of either five, six or seven parts of sand and gravel to one part of good Portland cement. If you wish to manufacture and compete with the best pressed brick, it will, of course, be necessary to use a greater proportion of cement. Figuring the cost of cement at $2.00 per barrel and sand at 50 cents a yard, the cost of a thousand brick would be a little more than $4.50.

This is exclusive of labor. If you will refer to the following pages of our catalogue, you will note that we show an estimated capacity for each size of brick machine. This information will enable you to figure out an approximate cost of production on a safe basis.

On the Harvard machine bricks are made 8 inches long, 3⅞ inches wide and 2⅜ inches thick, the size in most common use. If you do not have a concrete mixer, you should use much care that your cement and sand are properly mixed in the mortar box with a hoe and shovel before the water is added. Use a good sharp grade of sand. The finer the sand, the better the brick. Use a good standard grade of Portland cement, purchased of a reliable dealer. The material should be as dry as possible for the manufacture of brick.

By hand tamping, as done on the Harvard, it is possible to get a very much harder and more durable brick, with a better face than can be produced on many of the high priced so called hydraulic brick machines.

The Value of Cement Brick Over Other Brick

From the Cement Age, Atlanta, Ga., July, 1906.

"In considering the value and advantages of cement brick let us first arrive at a clear understanding as to why the idea of making a brick from concrete was ever adopted, why the originators of machinery for this purpose ever promoted the idea and, without being heralded to any great extent by the press, have brought the manufacture of cement brick to a highly recognized plane.

Cement brick is the inevitable natural result or culmination of the advantages of concrete and more durable brick construction combined. We today recognize concrete to be superior to brick or wood construction and cement brick must be further recognized to be the easiest form of concrete to handle and place in position and in keeping with all architectural laws. These points alone are sufficiently commendatory to warrant very serious consideration of this proposition by anyone new in, or thinking of entering, the concrete field.

Concrete is now used to such an extent that its superiority over other constructive materials has been fully proven and the public generally has become quite familiar with this fact; yet, withal its general use, we in no way find the general output of brick to be diminishing. Generally speaking, it is not a question of displacing brick with some other commodity, but producing a superior grade of brick which will displace the common product and give greater satisfaction.

In each and every phase it is found that the cement brick is an economic factor in the construction world. The cost of plant is found not to exceed one-tenth that of the clay or sand-lime brick plant.

The cost of brick will fluctuate according to grade and cost of materials in different localities, as well as to the extent of the equipment. The complete plant will produce the brick in competition with a clay brick; however, the selling price seldom runs below $8.00 per thousand for the cheapest grade of cement brick, the quality being such that this price is easily obtained. Brick made four to one brings from $10.00 to $12.00 per thousand and three to one brick still higher price. Experience has demonstrated that an $8.00 cement brick is cheaper than a $6.00 clay brick. The quality is far superior to the clay brick and the bricklayer asserts that he can lay them easier and faster. This is due to each brick being perfectly true and uniform and laying true in mortar, the same as a pressed brick. With the highest class of clay brick it is found necessary to gauge them for first class work. This is unnecessary with cement brick, especially where made on machines that press the brick face up. Freight is no small factor in the clay brick business, and this, of course, the consumer pays, whereas cement brick can be produced in practically all localities, putting a superior article in the hands of the user without excessive freights.

There is occasionally the opinion expressed that the drawback with the cement brick is the absorption, but tests have demonstrated that they absorb less water than a common clay or repressed clay brick, a fact which can be proven by anyone who will apply the test to samples of each.

When the brick is placed in the wall it absorbs less than the clay brick, and as the hardening process continues, the brick gets more impervious than any natural stone can be, while the clay brick lose rather than gain in this quality. The very element that hardens the cement brick causes the clay to deteriorate, chipping and breaking away until they must be replaced. In the same ratio that the quality of the clay brick deteriorates it applies to the appearance, while with the cement brick there is no change. The beauty of a cement brick wall is always impressive and noticeable, having the appearance of a very high grade of repressed clay, yet placed on the market in competition with common clay.

The uniformity refers not only to size but to color as well. The successful cement brick maker who gives proper attention to the production of quality is able to produce a run of brick without variation in color, though there are many conditions which influence the shade of the brick when made, even in natural colors, such as grades of sand, cement, temper, in mixing and application of water in curing.

Cement brick stand an excellent test in fire and have proven their qualities in this respect in many instances. In chimneys and fireplaces they have given excellent service; in fact, wherever used. They make a structure which is warm in winter and cool in summer, the brick being in no way affected by frost or by use on or below the ground line. Summing up the value of cement brick, we find they appeal to the user from the fact that he is getting full value for his money. He gets an article which, in clay, would cost him more than what he pays for it in cement. He gets a brick that will be laid up better, that will present a more pleasing appearance, that will grow better in quality instead of poorer.

In many instances the contractor, builder or user of large quantities of brick purchases his own outfit and makes them on the ground where they are to be used.

The success to be merited in the cement brick business of course depends on putting out a good brick at all times, never allowing an inferior article to reach the trade. A clear understanding of the use of cement is necessary. Success will rest with the use of good materials, their proper mixing and curing and equipment, consisting of good proven machinery."

Our Guarantee

Every Harvard Cement Brick Machine is guaranteed to be well made, perfectly fitted together and manufactured in a workmanlike manner. We guarantee every piece or part of the Harvard Cement Brick Machine to be free from flaws or defects of any kind, and will replace to you, free of charge, any part or casting showing any defect within one year from date of purchase. Every machine is thoroughly inspected before it leaves the factory. Because of the great amount of machine work done on the Harvard Cement Brick Machine, we are enabled to inspect these machines much closer than would be the case if it were a cast iron machine turned out from a foundry.

We Guarantee Safe Delivery

We guarantee safe delivery of every Harvard Cement Brick Machine. Every brick machine is carefully packed and securely crated for shipment. We guarantee safe delivery to your railroad station and will replace any part broken in transit and will prepay the transportation charges on such parts, so that you will be at no further expense.

A Profitable Business

The manufacture of brick from sand and cement on our Harvard Brick Machine is a good business proposition that appeals with equal force to a firm of large capital as well as to the man of more modest means. We know of no business which can be conducted with so much safety on such a small investment and which will insure a better profit on the same investment. Owing to the present cost of lumber, the demand for cement building blocks and cement brick is increasing and unlimited and is one of the best money making propositions open today. The Harvard Cement Brick Machine should be in the hands of every carpenter and contractor, every brick and stone yard, every dealer in building material, in fact is a splendid investment and right in line with the material sold by every cement, coal and lumber dealer in every part of the country. Think this proposition over, figure out the cost of material and labor and compare this with the selling price of brick and stone in your market. Under many varied conditions, most severe tests have been made on this machine, until we have thoroughly, by practical experiments, demonstrated our rights to the claims we make for the excellence and superiority of the Harvard Brick Machines.

Approximate Output

Five-brick size Harvard Cement Brick Machine, one man, 1,200 bricks per day; two men, 2,500 bricks per day.

Ten-brick size Harvard Cement Brick Machine, one man, 1,500 bricks per day; two men, 3,500 bricks per day.

Twenty-brick size Harvard Cement Brick Machine, two men, 4,000 bricks per day; three men, 6,000 bricks per day.

Forty-brick size Harvard Cement Brick Machine, two men, 4,000 bricks per day; six men, 12,000 bricks per day.

Ten-brick size Little Harvard Cement Brick Machine, one man, 1,200 bricks per day; two men, 2,500 bricks per day.

Five-brick size Little Harvard Cement Brick Machine, one man, 1,000 bricks per day; two men, 2,000 bricks per day.

Cost of Production

From information obtained from reliable manufacturers of cement brick we have ascertained that a barrel of cement will produce bricks of standard size as made on the Harvard Cement Brick Machines at the following proportions of mixture:

One barrel Portland cement will make about 470 bricks at a mixture of one to five.
One barrel Portland cement will make about 575 bricks at a mixture of one to six.
One barrel Portland cement will make about 750 bricks at a mixture of one to seven.

On the Harvard machine brick can be made at from $3.50 to $5.50 per thousand, the cost being governed by the cost of labor and material. If you are interested, we ask you to ascertain the cost of sand, cement and labor at the point where you wish to operate a machine, and by referring to approximate output and estimated number of bricks that can be made with one barrel cement, you will have a very close estimate of the actual cost per thousand to manufacture in your community. As these brick, on account of their superior qualities, sell for from $2.00 to $10.00 per thousand more than clay brick, you can readily arrive at the margin of profit you would have. This estimate would be based on brick 8 inches long, 3⅞ inches wide and 2⅜ inches thick, the size produced by our machine, which is the size in common use.

In addition to the ordinary brick produced by the Harvard machine they can be made in any color or any style of ornamental face. If desired, the face of the brick (plain or ornamental) can be made of a richer material (either colored or natural), the result being a brick of very high grade that will command a price at least double that of ordinary brick. Brick made by this process is equal to pressed brick in appearance, superior in quality, and the additional expense of facing is small.

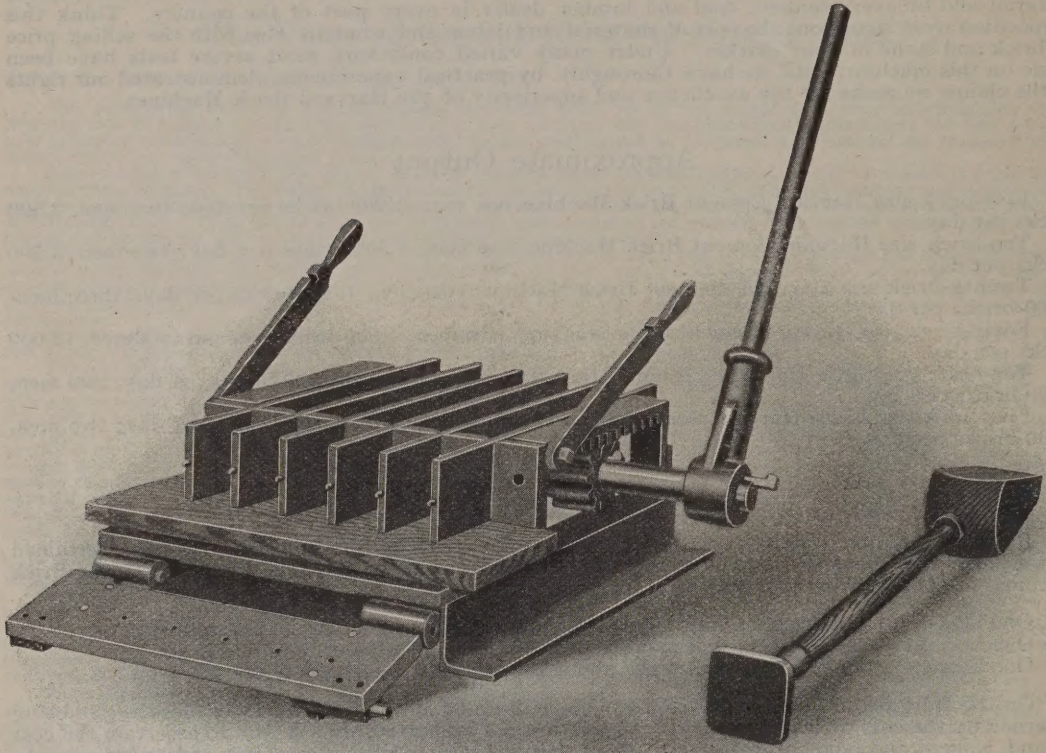
Harvard Cement Brick Machines are shipped complete with tamper, straightedge and sample pallets. Additional wood pallets can be made and furnished by any planing mill at a little more than the cost of the lumber. Octagon and circle brick of any desired radius are easily made by backing the pockets with iron plates, which we can furnish for that purpose. Plates for special and fancy shapes can be furnished. See illustrations of various designs of faces on another page.

For ordinary brick common sand is productive of best results. For cheap brick, to be used in backing or rough construction, sand containing gravel up to the size of a walnut may be safely used. Brick of this quality are made by using a proportion of five, six or seven parts of sand and gravel to one part of good Portland cement. If you wish to compete with best pressed brick it will of course be necessary to use a greater proportion of cement.

If you contemplate engaging in this business, the first step for you to take is to secure a machine that, at lowest expense for labor, will produce satisfactory results every day it is in operation; in other words, **"a machine of quality."** We know the Harvard is the most rapid, practical, durable and will produce a better brick at less cost than any other machine of its kind on the market and, when these points are taken into consideration, we are confident you will select a Harvard—**"the machine of quality."**

Little Harvard Cement Brick Machine

Without Stand or Base, Five-Brick Size



ESTIMATED capacity of this machine, with one man, about 1,000 bricks per day. With two men, capacity can be increased to 2,000 to 2,500 bricks per day. The Little Harvard Brick Machine can be used with either wood pallets or steel face pallets. The above illustration shows the machine fitted with wood pallet. This machine will not produce ornamental brick. We furnish a trowel with this brick machine to enable you to put a smooth face on the edge of your bricks when making them. By just a little care you can form a brick with all four sides as true and even as with the larger machines which have the drop door for facing. If you purchase this machine without the base or stand, we would recommend that you build a heavy table, about 2 feet or 2½ feet high, and bolt the machine to it. It is possible that you can build a good substantial table or stand out of wood for less than we will have to charge you for the heavy cast iron stand which we can furnish.

The face plate and rear wall plate, as well as the dividing guides, are machined and are absolutely true and produce a perfect brick, 8 inches long, 3⅞ inches wide and 2⅜ inches thick, which is the size most generally used. We can furnish a base or stand for the Little Harvard Brick Machine when so specified. With this size of machine we furnish one tamper, one trowel, one wood pallet, one steel face pallet.

No. 63A2001 Little Harvard 5-Brick Size Machine, without base or legs. Weight, 200 pounds. Price........ **$46.50**

No. 63A2002 Little Harvard 5-Brick Size Machine, with base or legs. Weight, 300 pounds. Price........ **54.50**

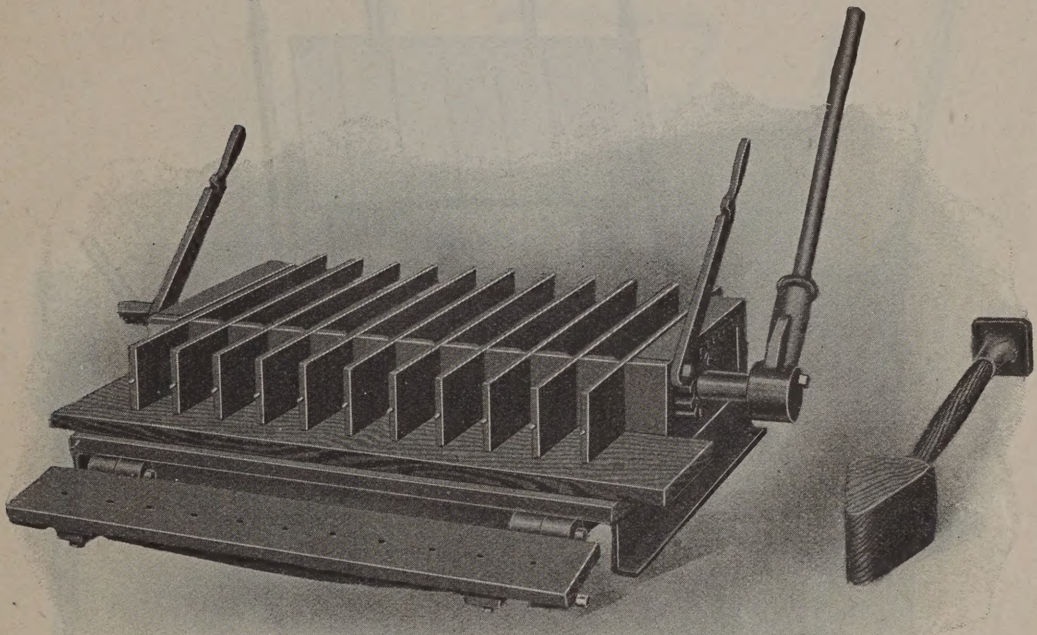
No. 63A2003 Base or Stand for above machine. Weight, about 70 pounds. Price... **8.00**

No. 63A2004 Filling Table for above machine. Weight, about 15 pounds. Price..... **3.35**

No. 63A2040 Steel Faced Pallets for above machine. Weight, 5 pounds. Price, each.. **.24**

Little Harvard Cement Brick Machine

Without Stand or Base, Ten-Brick Size



THE estimated capacity of this handy size brick machine, with one man, is 1,200 bricks per day. Two men will produce 2,500 or more bricks per day. The capacity of these machines depends a great deal upon the operators and how well equipped your yard may be for handling and curing the brick. We manufacture the Little Harvard Cement Brick Machine in two sizes to meet a demand for a low priced yet thoroughly accurate and reliable machine. You cannot make ornamental face designs on either size of the Little Harvard Brick Machines, but all the standard Harvard Brick Machines are arranged with a heavy face plate or hinged cover, making it an easy matter to use ornamental face plates.

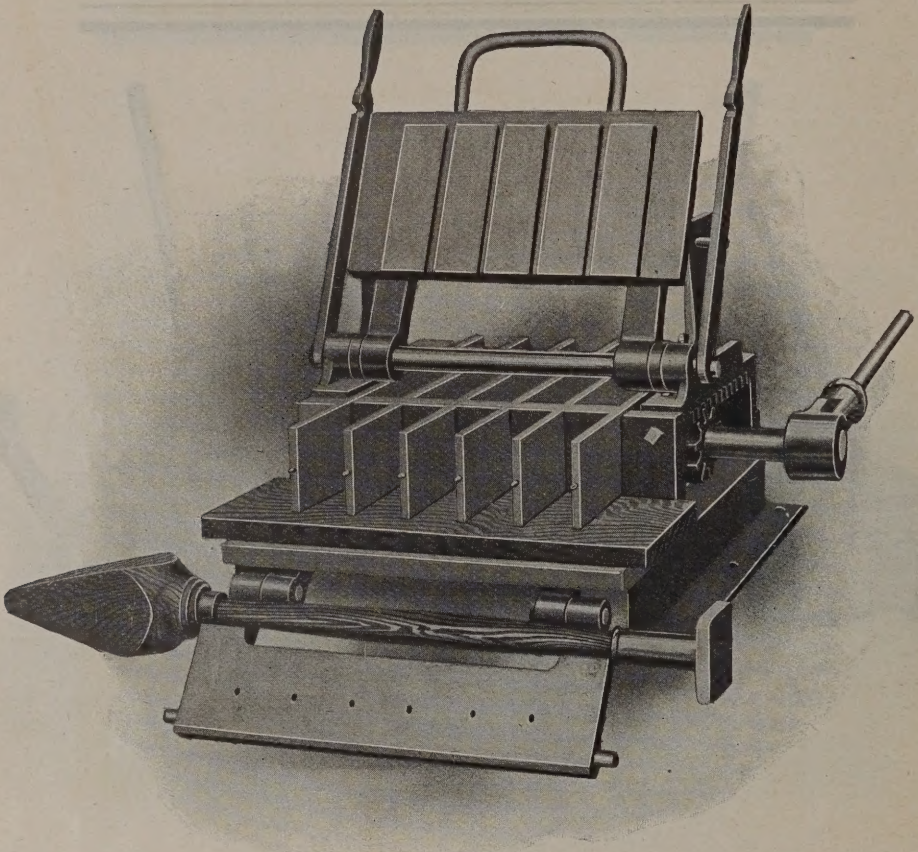
In making brick with the Little Harvard Machines, the top of the brick should be carefully troweled when finishing, so that the brick will be absolutely true and smooth. This machine is well made, the front and back walls of the mould box, together with the steel partition or dividing plates, are carefully machined, thereby insuring a perfect brick.

We can furnish the Little Harvard Cement Brick Machine either with or without base or stand, when so ordered. With this size of machine we furnish one tamper one trowel, one wood pallet, one steel face pallet.

No. 63A2006	Little Harvard 10-Brick Size Machine, without base or legs. Weight, 400 pounds. Price	$63.25
No. 63A2007	Little Harvard 10-Brick Size Machine, with base or legs. Weight, 500 pounds. Price	73.25
No. 63A2008	Base or Stand for above machine. Weight, about 80 pounds. Price	10.00
No. 63A2009	Filling Table for above machine. Weight, about 20 pounds. Price	5.35
No. 63A2042	Steel Faced Pallets for above machine. Weight, 9 pounds. Price, each	.33

The Harvard Cement Brick Machine

Without Stand or Base, Five-Brick Size



EVERY machine in our entire line of regular Harvard Cement Brick Machines is fitted up with a heavy facing door or cover, which is attached to the top of the machine by heavy steel shafts and has steel plates made for facing the top edge of the brick. The faces on this hinged cover are machined and are absolutely true and perfectly smooth. The front door drops down out of the way of the bottom to enable you to carry away the pallet with bricks These machines are made to use either wood or steel pallets The divisional plates or guides are made of cast steel and are machined and worked between guides on the rear of the machine, which causes them to travel in a direct line when being withdrawn from the brick. The front door and rear wall are machined and we claim that our line of Harvard Brick Machines will produce a strictly first class brick, a brick with four sides absolutely true and perfect. It is absolutely impossible for any guide or slide to mar or deface the side of a brick when being withdrawn. See pages 117 and 118 for different designs of ornamental faces, five of which we furnish with this machine. Select the design wanted. You may select five of a single design or one each of the five different designs, according to your fancy.

We furnish this five-brick size of Harvard Cement Brick Machine either with or without base or stand as ordered. The regular equipment for this brick machine is the following: One tamper, one wood pallet, one steel face pallet, one filling board, five ornamental face moulds (choice of any design).

No. 63A2015 Harvard Cement Brick Machine, 5-brick size, without stand or base. Weight, 300 pounds. Price...**$55.00**

No. 63A2016 Harvard Cement Brick Machine, 5-brick size, with base or stand Weight, 400 pounds. Price... **67.50**

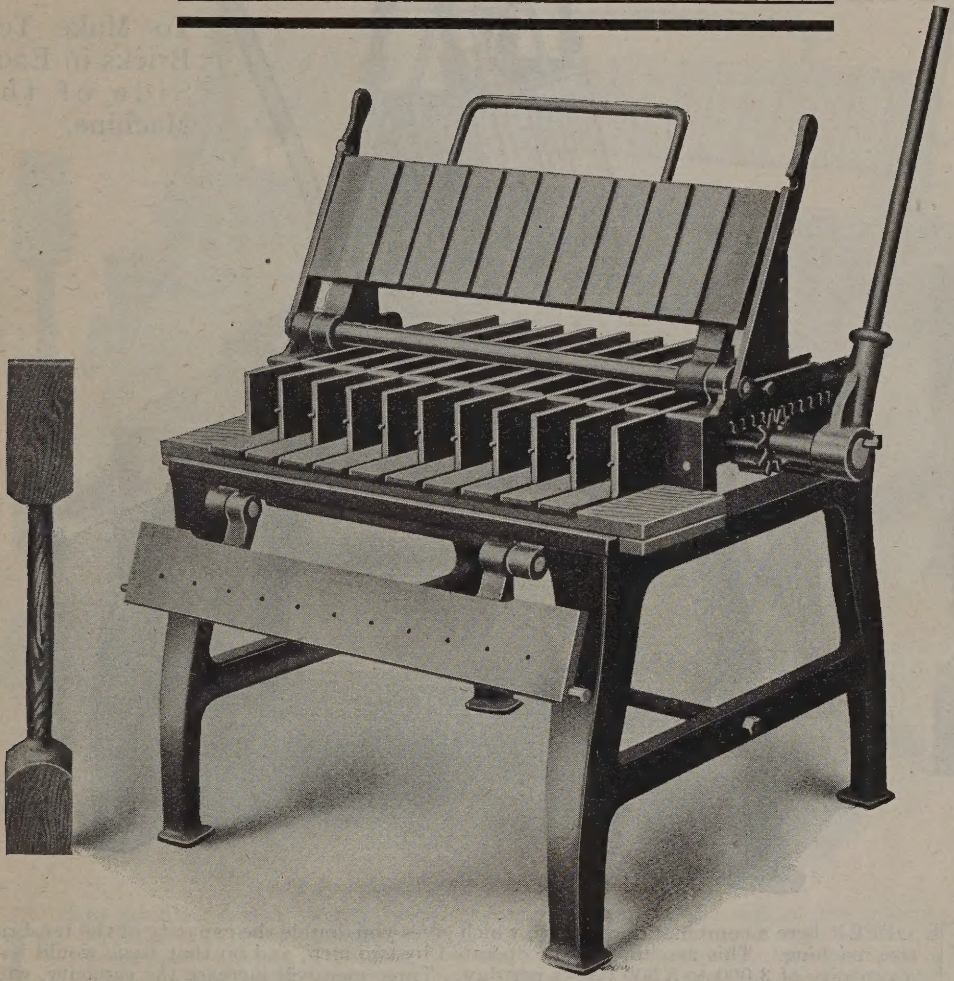
No. 63A2017 Base or Stand for above machine. Weight about 100 pounds. Price.... **12.50**

No. 63A2040 Steel Faced Pallets for above machine. Weight, 5 pounds. Price, each.. **.24**

NOTE—You will require enough pallets to enable you to do a full day's work. Bricks must remain on the pallets until cured. We furnish a sample wood pallet with each machine.

The Harvard Cement Brick Machine

With Base or Stand, Ten-Brick Size



THIS machine is well adapted for any builder or contractor or manufacturer of cement building blocks and brick. This machine has a capacity of about 1,500 bricks per day when operated by one man, or two men will make about 3,500 bricks per day. A third man working on the machine, helping to mix and carry away the brick, would increase its capacity considerably. This machine is sold only on the base or stand as shown in the above illustration. We show this machine fitted up with a steel pallet and plain faces on the hinge cover of the machine. With this machine we furnish ten ornamental face designs for facing the edges of the brick. You may select ten faces of the same kind or you may select an assortment of the different faces as you choose. The front door, the steel guides or dividing plates, the rear wall of the machine, as well as the top cover, are all machined and absolutely true and make ten bricks at an operation that are absolutely perfect on all four sides and both ends. All of our Harvard Brick Machines make a standard size brick, namely 8 inches long, 2⅜ inches thick and 3⅞ inches wide.

We furnish the Harvard Cement Brick Machine, ten-brick size, with the following equipment: One wood tamper, one filling board, one wood pallet, one steel faced pallet, ten ornamental face moulds (choice of any design).

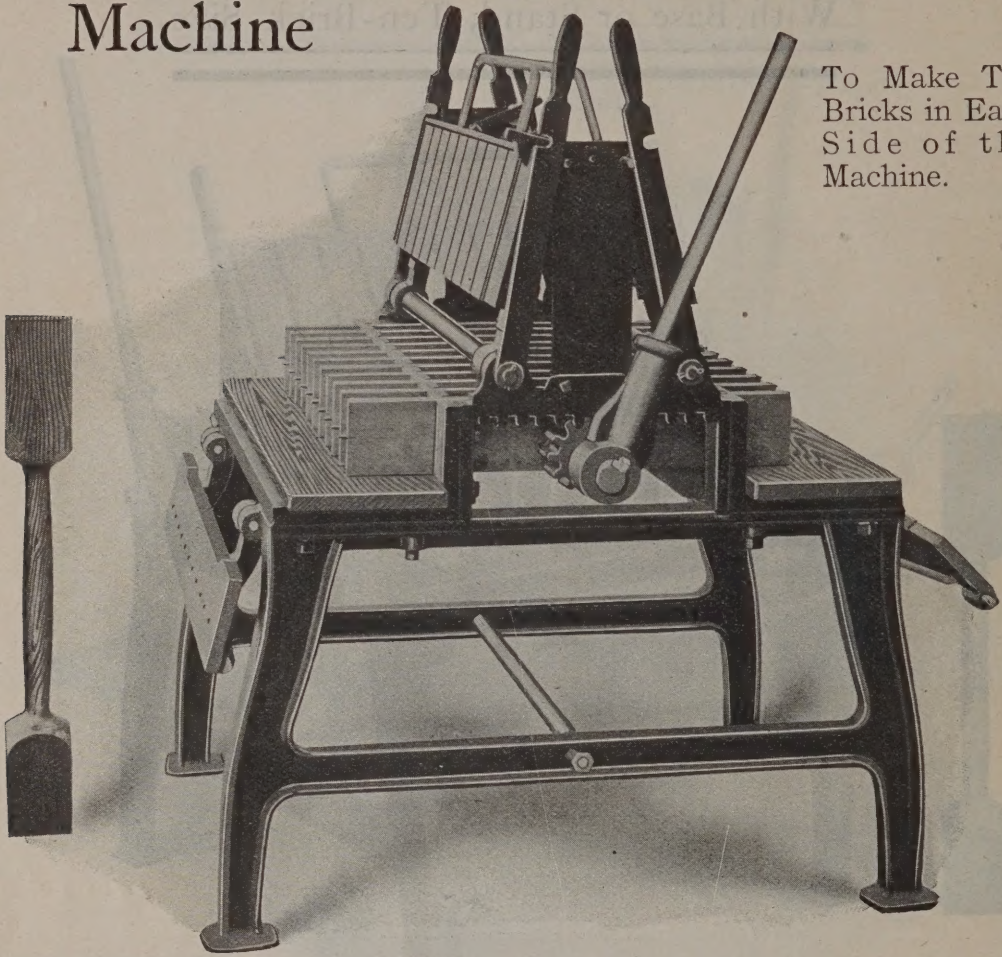
No. 63A2020 Harvard 10-Brick Size Machine, mounted on stand, complete. Weight, 700 pounds. Price **$133.25**

No. 63A2042 Steel Faced Pallets for above machine. Weight, 9 pounds. Price, each . . **.33**

NOTE—We furnish a sample wood pallet with the machine and if you prefer to use pallets of your own make, you should select good lumber, well seasoned, and a few coats of good boiling linseed oil applied with a brush when the oil is very hot will sometimes prevent the wood from warping. Your pallets must be absolutely true.

The "Double Ten" Harvard Brick Machine

To Make Ten Bricks in Each Side of the Machine.



WE OFFER here a combination machine which gives you double the capacity of the ten-brick size machine. This machine can be operated by two men, and on that basis would have a capacity of 3,000 to 3,500 bricks per day. Three men will increase the capacity, while four or even five men will more than double the capacity of the machine. Four men can work on the machine to good advantage and a fifth man can be used for mixing the concrete. This machine is so constructed that but one set of dividing plates or guides is used in the double machine. While a brick is being made on one side of the machine, the bricks are being carried away from the other side of the machine and a new pallet placed in position, the front door closed and locked, by which time the bricks have been made on the other side of the machine, and, as you withdraw the steel guides from the mould or brick just finished, you force the guides back into the brick chamber on the opposite side of the machine and the other set of men commence making brick. Both sides of the machine are provided with the heavy facing door, the same as in the regular ten-brick size machine and with the "Double Ten" Harvard Cement Brick Machine we furnish twenty different face moulds for ornamental faces. We will send you twenty of the single kind, or we will divide them up into any assortment you may choose.

With the "Double Ten" Harvard Cement Brick Machine we furnish the following outfit: Two wood tampers, two filling boards, two steel faced pallets, two sample wood pallets, twenty ornamental face moulds (choice of any design).

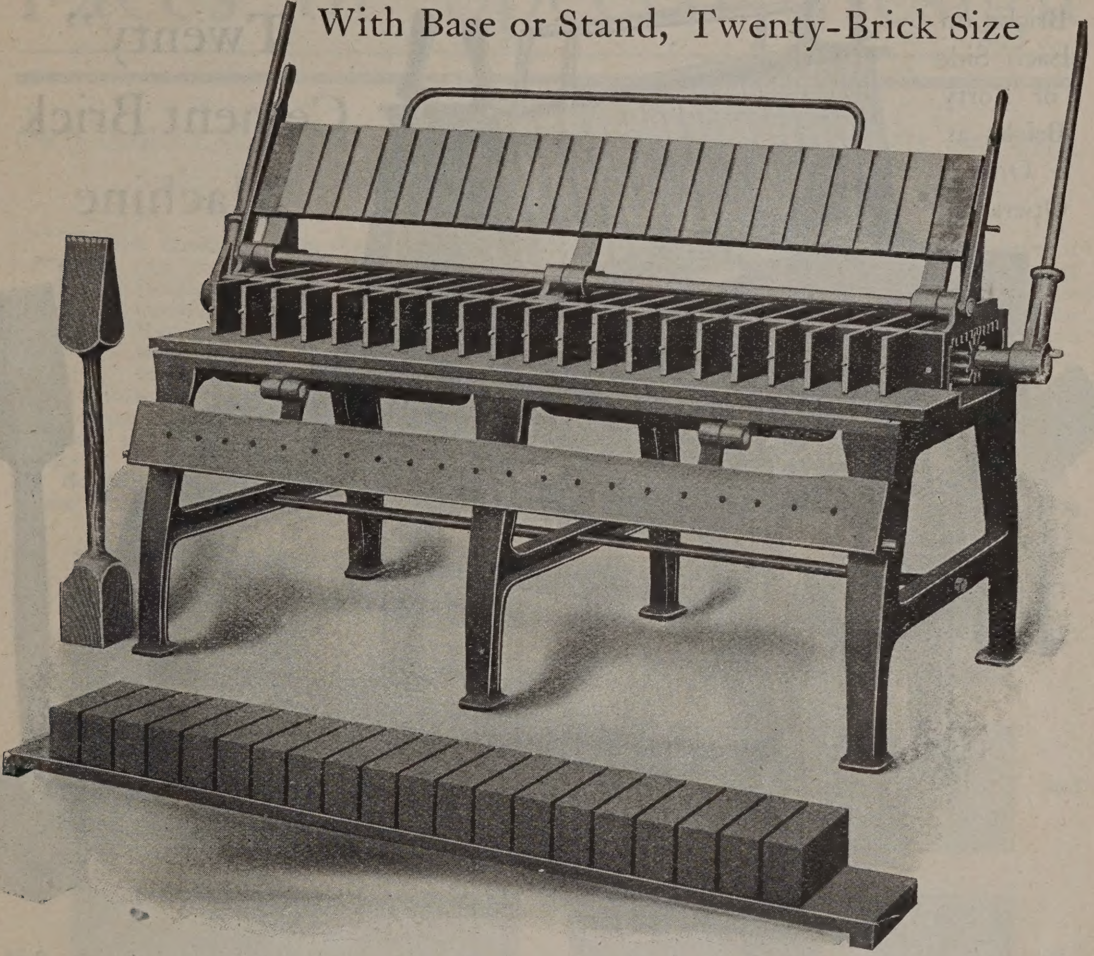
No. 63A2024 Harvard "Double Ten" Cement Brick Machine, makes twenty bricks, ten bricks at a time on each side, mounted on base or stand. Weight of complete outfit, as shown, about 1,000 pounds. Price.. **$182.50**

No. 63A2042 Steel Face Pallets for above machine. Weight, 9 pounds each. Price, each, **.33**

NOTE—The Harvard "Double Ten" Size Brick Machine requires just double the amount of pallets that are used on the regular ten-brick size. The number of pallets you will require depends on how many men you work on the machine. The brick should be allowed to remain on the pallets until well cured.

The Harvard Cement Brick Machine

With Base or Stand, Twenty-Brick Size



THIS machine makes twenty bricks at an operation on one side of the machine. This machine is adapted to large brickyards and the use of contractors and builders who use a great many bricks. The capacity of the Twenty-Brick Size Harvard Machine, with two men, is about 4,000 bricks per day. Three men will turn out about 6,000 bricks per day while another man would add very materially to the output.

The Twenty-Brick Size Harvard Cement Brick Machine is a massive machine, weighing 1,450 pounds, and has three pairs of heavy legs for a stand. The front door, as well as the steel dividing plates or guides, the rear wall of the brick chamber and the steel facing plates on the facing cover or lid of the machine are all machined and are absolutely true and perfectly smooth. This machine produces standard size bricks of the very finest quality. The corners and edges are as square and true as any Philadelphia pressed brick ever made, and the sides and edges of the brick are smooth and perfect in every detail.

This size of brick machine is provided with two end levers for withdrawing the dividing plates or guides. These dividing plates should be withdrawn by two men, one at each end of the machine. The facing door or top cover is very heavy and requires two good strong men to raise and lower it in facing the brick.

With this machine we furnish a full set of twenty ornamental face moulds, either of one single design or of any assortment that you may pick out. The illustration at the lower edge of the above cut shows a pallet with twenty bricks as removed from the machine.

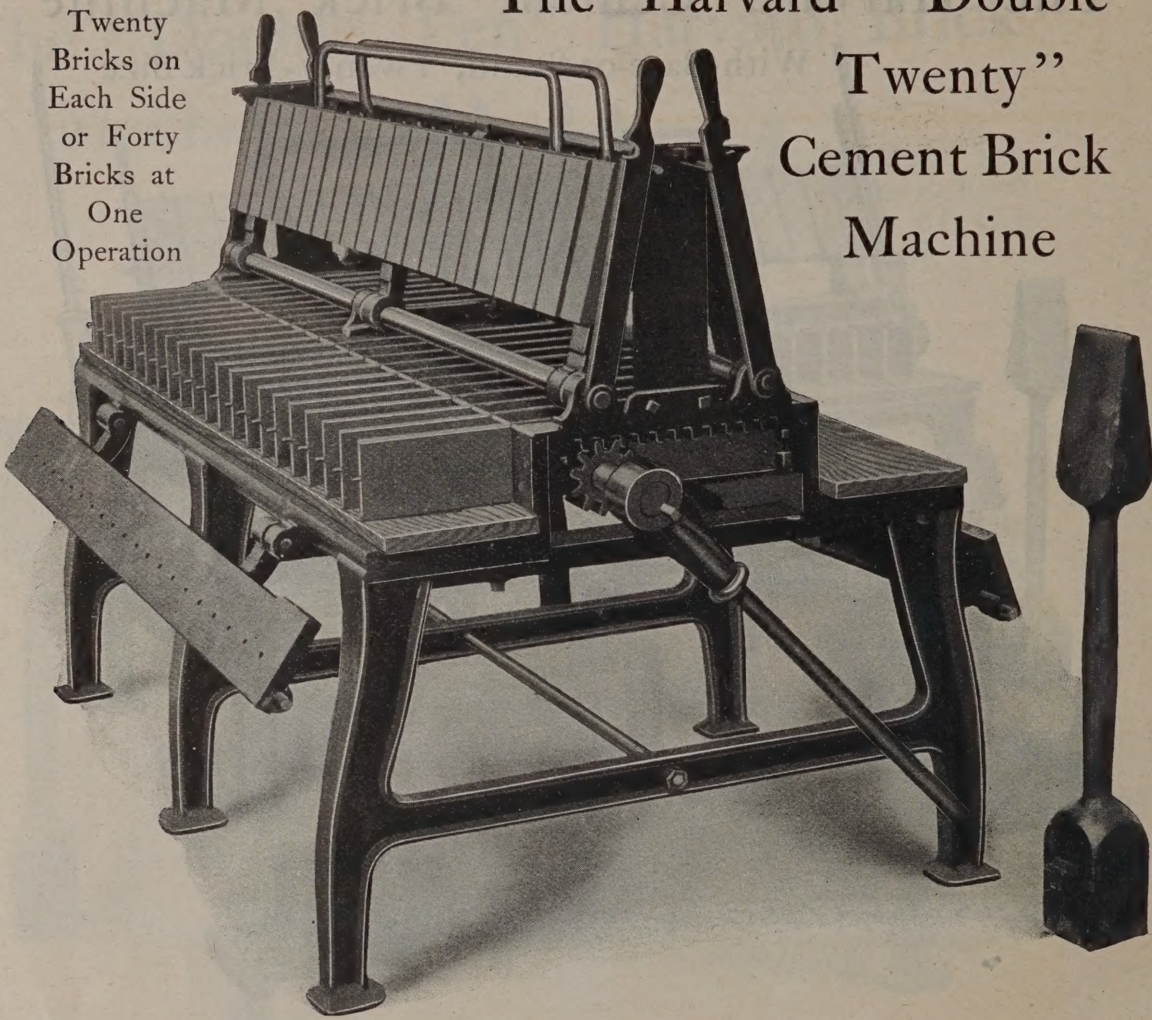
With the Harvard Cement Brick Machine of this size we furnish the following equipment: One wood tamper, one filling board, one steel faced pallet, one sample wood pallet, twenty ornamental face moulds (choice of any design).

No. 63A2028 Harvard Cement Brick Machine, makes twenty bricks on one side at one operation, mounted on base or stand Weight 1,450 pounds. Price.......................**$200.00**

No 63A2044 Steel Faced Pallets for above machine. Weight, 16 pounds Price, each.. **.52**

The Harvard "Double Twenty" Cement Brick Machine

Makes Twenty Bricks on Each Side or Forty Bricks at One Operation



THE Harvard Forty-Brick Machine is especially adapted for large cement brick manufacturers, large contractors and builders or anyone going into the cement stone or brick business. This machine, like all of the other Harvard machines, is easily transported from one place to another when it may be to your interest to move the machine to the job of work and erect temporary sheds for making and curing the brick. This would be cheaper than hauling the brick to the job after they have been made. The Forty-Brick Size Harvard Cement Brick Machine can be operated with four men with a capacity of from 5,000 to 6,000 bricks per day, while six men could easily make 12,000, and by adding another man or two for mixing material and helping to carry away the brick, this capacity could be increased. The "Double Twenty" Size Harvard Brick Machine is built along the same general lines as the regular twenty-brick machine, other than it is fitted up with a mould box on each side of the machine. The above illustration shows the dividing guides or plates withdrawn from the brick mould on the opposite side of machine, the front door on the front side of the machine is now ready to be closed and locked and a set of bricks made on this side of the machine. This illustration shows the machine fitted with two wood pallets.

This machine is furnished with forty ornamental face moulds. We furnish twenty moulds of two different designs or forty moulds of one design, or will give you an assortment of any ornamental faces wanted.

With the Harvard Forty-Brick Machine we furnish the following outfit: Two wood tampers, two filling boards, two steel faced pallets, two sample wood pallets, forty ornamental face moulds (choice of any design).

No. 63A2032 The Harvard Forty-Brick Size Cement Brick Machine, makes twenty bricks on a side, mounted on base or stand. Weight, complete, of the above outfit, 1,600 pounds. Price.. **$230.00**

No. 63A2044 Steel Faced Pallets for above machine. Weight, 16 pounds. Price, each. **.52**

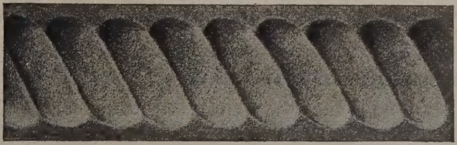
Faces of Special Design

ORNAMENTAL FACE PLATES WHICH MAY BE USED ON THE HARVARD CEMENT BRICK MACHINE

THE illustrations on this and the following page show the different ornamental faces that can be made on the Harvard Cement Brick Machine You cannot make ornamental faces on the Little Harvard Five-Brick and Ten-Brick Machines. These ornamental face moulds or blanks are attached to the drop cover or hinged door of all of the regular Harvard Cement Brick Machines. They are attached to this hinged door by means of a set screw, making it an easy matter to attach or remove them. There are eighteen different designs of faces, and we furnish a complete set for each Harvard Machine, according to the number of bricks made on the machine. This set is furnished with the machine, and at no extra charge. We can furnish additional designs with your machine, or at any future time, as wanted. In ordering a machine specify the style of ornamental faces wanted by giving the style number. In ordering additional designs of face moulds give the catalogue number.

No. 63A2050 Ornamental Design Face Mould, as shown below and on following page, choice of any design. Give number of design when ordering. Price, each.................. **75c**

No. 1



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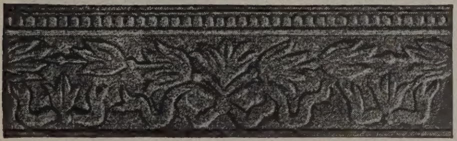
No. 3



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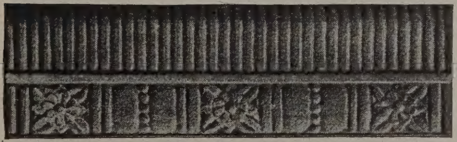

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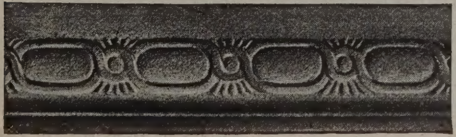

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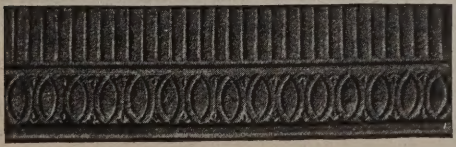
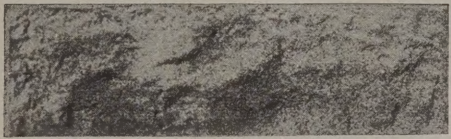


No. 7



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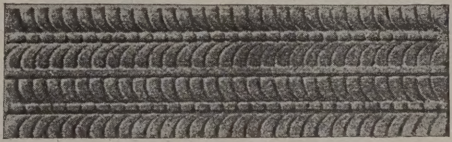

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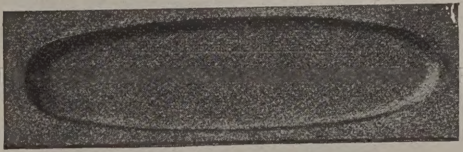
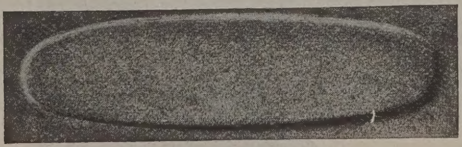


No. 10



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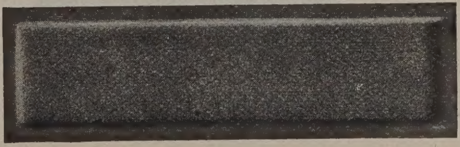

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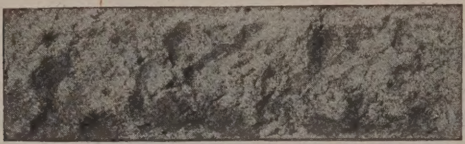
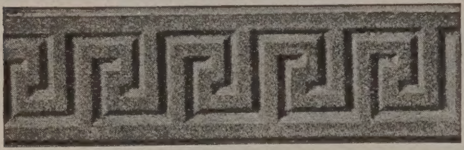
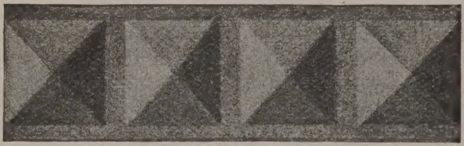
No. 13



No. 14



No. 15



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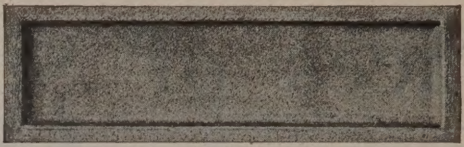

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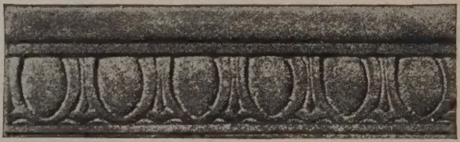
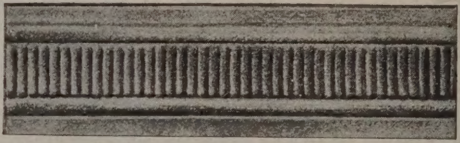


No. 18



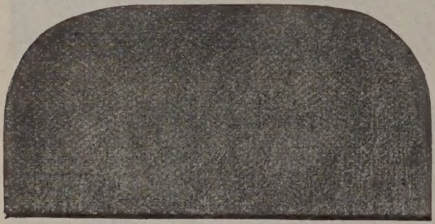
Corner Moulds for Making Different Styles and Shapes of Cement Brick

In building brick buildings it is sometimes necessary to use round corner or irregular shaped brick. The brick with one single round corner is frequently used on corners of buildings. It is also used for laying up a wall around a window or door opening. You can also use the brick with two round corners for building up a single course of brick in the center of a mullion window. All of these irregular style bricks are frequently used in building copings and belt courses on brick buildings. The keystone brick is used for building arches over windows and doors, in gables, etc. There are many uses for these bricks.

We can furnish corner moulds for making various shaped bricks in any of the designs shown in the illustrations. These corner moulds are not furnished with the machine but must be purchased as extras.

No. 63A2049 Cast Iron Corner Blocks for making irregular shapes of brick, as shown in the illustrations. Price, each... **37½c**

No 1



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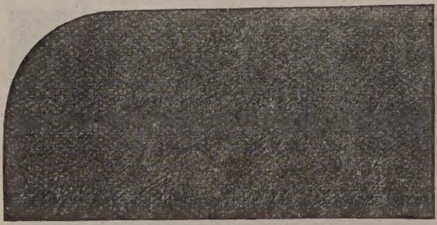

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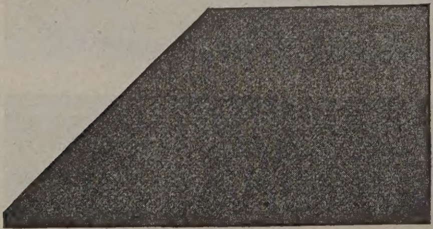


No. 4

No. 5

ALL WE CLAIM FOR IT.

Jefferson, Wis., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I am using the Buckeye Cement Block Machine purchased from you and must say it is all you claim for it. The machine will make as good a block and as quick as any other machine, and every one that said anything about the blocks said they were the nicest in town.

Yours truly,

S. HAKE.

Instructions for Operating Harvard Brick Machines

The machine should be placed on a good solid floor and carefully leveled. Remove all grease from moulds with kerosene. Oil all working parts thoroughly with some good lubricant.

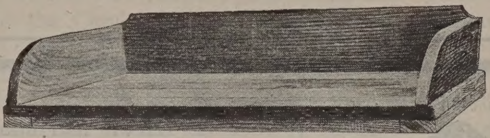
First. Place pallet in machine, raise front door, lower side levers, bring slides forward against front door, place straightedge in position on back of moulds against lid, so material will more readily fall into place.

Second. Fill moulds heaping full and strike each mould twice with tamper. Complete filling moulds and straightedge off surplus material.

Third. Drop lid forcibly, following up with one or two quick sharp blows.

Fourth. Withdraw slides, raise lid, raise side levers, lower front door, slide pallet forward, take away face of mould and remove brick to rack.

This entire operation can be performed in less than a minute, and is so simple that a little practice is all that is required to enable anyone to operate the machine with rapidity and ease.

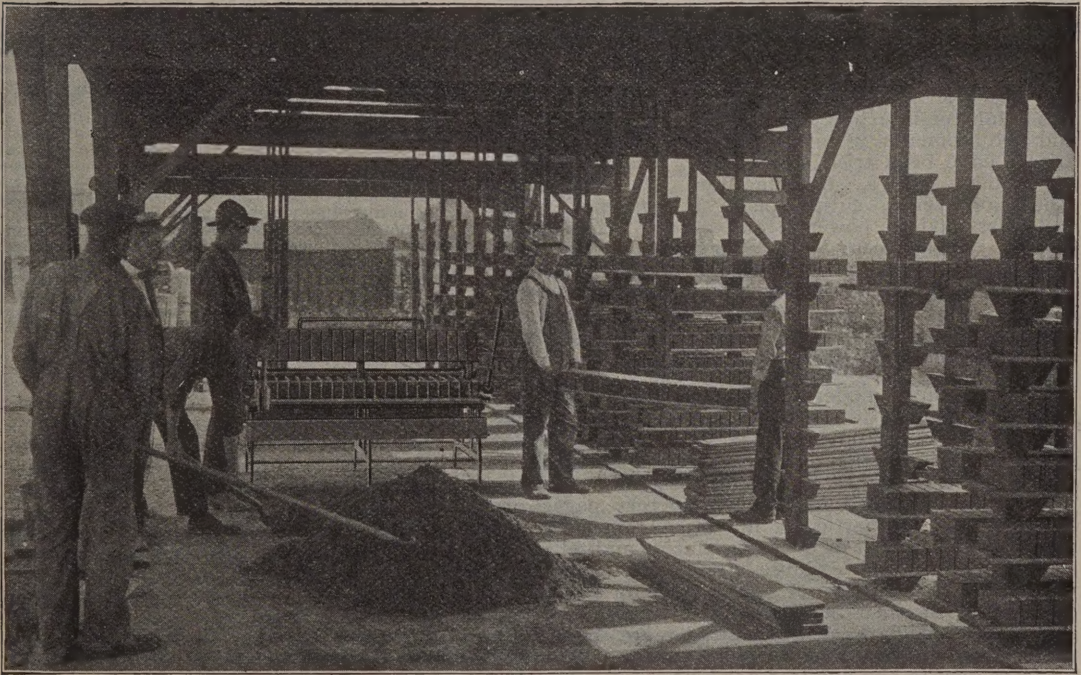


This Illustration Shows Wood Filling Table used with the two sizes of Little Harvard Cement Brick Machine. This Filling Table is made in two sizes, namely: For the five-brick and for the ten-brick machine. (See Page 111 for weight and prices of Little Harvard Brick Machine.)

After brick have been placed in rack they should be permitted to stand on pallets until they set sufficiently to permit removal. This takes from twelve to fifteen hours under normal weather conditions. Then remove to pile and water thoroughly at least four or five days.

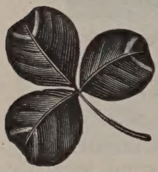
Sand cement brick increase their strength with age, but in good weather and with proper curing they will be ready to be used in the wall in from fifteen to twenty days.

An Up to Date Cement Brick Yard



WE REPRODUCE herewith a photograph of a thoroughly equipped brick yard, located at Michigan City, Indiana. This man is using the Harvard Cement Brick Machines, and has built a shed for curing and drying brick that is well designed for obtaining best results in curing, and it was erected at a moderate expense. Note the construction of the racks on which the trays or pallets rest while curing brick. Cement brick should not be exposed to the hot sun. We recommend that any manufacturer of cement brick erect curing racks along the line of those shown in the above illustration. This party is using one of our "Double Twenty" or Forty-Brick Size Harvard Cement Brick Machines.

CLOVER LEAF CONCRETE MIXING MACHINES



WE HAVE had numerous inquiries for concrete mixers ever since we have been handling cement building block machines. We have had inquiries from large contractors for big power machines of various sizes and capacities down to the small hand mixers, such as should be found beside every cement block or cement brick machine. We have sold cement block machines for a considerable length of time and during that period have spent much time investigating the advantages and disadvantages of mixing concrete by hand and by machine. We have obtained much of this information from manufacturers and large dealers in cement blocks, cement brick, etc., and finding that there is a universal demand for a good mixer, we set about to obtain a machine that we could place in the hands of our customers at a fair and reasonable price. Most manufacturers of cement and concrete mixers put enormous stress on the fact that their machine is patented, etc. Their prices have been exorbitantly high and away out of the reach of any but the very largest contractors who could afford to pay a big sum for machines of this kind. In our line of concrete working machinery we give every customer a **square deal.** We cannot afford to offer you a concrete mixer of any size or kind without first knowing that it will do the work it is represented and required to do. To best ascertain these results from any machine it is necessary that the machines be thoroughly tried and tested in actual work.

The line of concrete mixing machines shown in this catalogue is a line that fulfills our expectations and requirements in every respect. Our concrete mixers have been tried and tested. These machines are built by a manufacturer of established reputation whose entire plant is equipped with the most modern, powerful and speedy machines to be had. This concern builds a good many other kinds of machines, and their knowledge of proportioning and designing machinery is worthy of the most careful consideration. These machines are designed by mechanical engineers whose entire work and study is to develop and build high class machines.

In a paper read before a recent meeting of the National Association of Cement Users, we find some comments made by Prof. S. B. Newberry, a recognized authority on cement and its uses, which we wish you would note:

"Hand mixing is always imperfect, laborious and slow, and it is impossible by this method to secure the thorough stirring and kneading action which a good mixing machine gives. If a machine taking several horse power requires a given time to mix a certain amount of concrete, it is of course absurd to expect that two men will do the same work by hand in the same time, and the machine never gets tired or shirks if not constantly urged, as is the nature of men to do. It is hard to see how the manufacture of concrete blocks can be carried on successfully without a concrete mixer. Even for a small business, it will pay well in the economy of labor and excellence of work to install such a machine, which may be driven by a small electric motor or gasoline engine. In work necessarily so exact as this, requiring perfectly uniform mixture, and use of a constant percentage of water, batch mixers, which take a measured quantity of material, mix it and discharge it at each operation, are the only satisfactory type, and continuous mixers are unsuitable."

By reason of modern equipment and the large volume of work turned out yearly, this manufacturer is enabled to exercise a purchasing power most valuable in securing raw material at reasonable prices and of standard makes and grades. Knowing the enormous output possible for us to sell in this or any other line of machines, enables us to secure a most favorable contract with these manufacturers; enables us to offer these mixers at prices which permit our selling them at very low prices. As explained in the introductory pages of this catalogue, our expense in selling and handling any one particular line of machinery is indeed small as compared with the cost of any manufacturer, jobber or dealer in placing and selling the same line of machines through local agents, salesmen, etc., whose expense always add so much to the real cost of the goods by the time they reach you. In figuring our selling price on this line of concrete mixers, we have eliminated many items of expense such as traveling salesmen, commissions, hotel and railroad bills, etc., and we are selling these machines at figures that represent a manufacturer's cost, together with our one small profit added. These same machines, when sold on the road by salesmen or agents, are usually sold for from fifty to one hundred per cent more money than the prices quoted in this catalogue.

Every concrete mixer is warranted to do the work claimed for it and to produce the quantity at which it is rated, without pushing or crowding the machine. The measurements given in this catalogue are absolutely correct and the capacity is based on the normal rate of speed. The work on these machines is well done; the cast iron parts where fitted together, are machined so as to produce absolutely perfect fitting joints. We have endeavored to give you all of the information possible in the descriptive matter of these machines. We have endeavored to make it so very plain and thorough that it will not be even necessary for you to write us for any additional information, and you will not have the slightest trouble in operating any of these machines.

In taking up the sale of this line of concrete mixers, we did so after thoroughly investigating the necessity of a machine of this kind in the hands of the average concrete worker and our investigation has led us to see the advisability and necessity of using a machine for mixing concrete, and any good mixer will soon pay for itself, not only in the saving in the expense of handling the concrete, but it always insures better results as it thoroughly prepares a mixture that is always absolutely even.

The Clover Leaf Concrete Mixer

The Clover Leaf Mixer is a high grade batch concrete mixer. We furnish this machine in different sizes, both for hand and power. The mechanism of the Clover Leaf Mixer is without question built upon correct scientific lines to produce the results necessary to successfully mix any batch of material. The Clover Leaf Concrete Mixer has no inside mechanism to become clogged up and to form a body or place for cement to lodge, stick and accumulate during the operation of the mixer. The charge within the mixer passes freely of its own weight and movement over the inside of the drum. The angles for different positions of the drum during each revolution are shifting constantly, every position being in a direct line of movement of the particles being mixed. In the Clover Leaf Concrete Mixer there is absolutely no possibility of the finer and coarser aggregates becoming separated, because, as shown in the illustration on page 129, if the drum revolves it follows the lines on which the concrete will fall across from one side of the drum to the other. For instance, the material resting on the bottom of the drum and carried upward after the drum revolves is gradually drawn forward and of its own weight is carried along the surface across the entire width of the hopper, and because of the oscillating motion of the machine caused by the angles of the drum, the material is shifted, not only from one side to the other in the drum, but is also shifted from one end to the other from left to right, thus securing eight different movements of the contents of the drum or mixer during each revolution. The entire mass is thoroughly shifted and its position changed so often during the process of mixing that it assures uniform concrete of the highest degree, both as to the proportioning of the fine and coarser materials, which you will appreciate is of much importance, especially where you are using crushed stone, sand and cement in one batch. The motion of the drum guarantees a perfect and even distribution of the cement with all the aggregates, whether large or small.

Every Clover Leaf Concrete Mixer is guaranteed not to ball or roll the concrete and that it positively turns over and scatters every particle of the batch with each upward movement of an angle or part of the cylinder. The drum or mixer is without webs, wings or deflectors of any kind, in fact it has no inside mechanism to get out of order, clog up the machine or to allow the concrete to collect, as you will observe from the illustrations shown elsewhere explaining the interior motion of the machine, causing three distinct angles or positions of the batch at each revolution.

Each size of machine is easy of access, there being a simple arrangement of one cross rod provided with a toggle latch for instantly detaching and removing this rod, enabling you to take out one large section of the drum to get into the machine to clean it out. The power machines are all loaded or set and the contents discharged while the machine is running. You may unload or discharge either the entire batch of concrete or such part of it as is wanted. On the following pages we show illustrations of the different sizes of the Clover Leaf Concrete Batch Mixers and have endeavored with each illustration to give you as much information as we think would be wanted in the way of measurements of the different parts, diameters of the different drums, both inside and outside, speed method of operating, etc. If there is anything pertaining to these Clover Leaf Concrete Mixers that we have overlooked, if there is any information which you wish to obtain and which is not contained in this catalogue, we will be pleased to have you write us and your letter will be answered by an experienced correspondent who is entirely familiar with the working of these machines.

A CONCRETE MIXER IS INDISPENSABLE

An editorial in a leading publication, under this caption, treats the subject as follows:

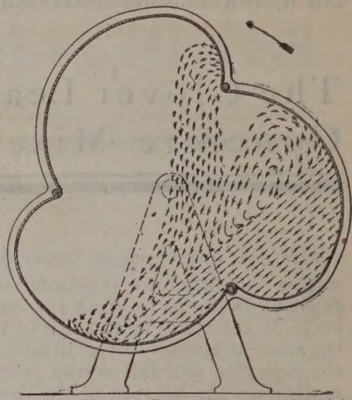
"It has been developed beyond a shadow of doubt that the proper mixing of the material for the manufacture of Concrete Building Blocks cannot be accomplished in a very satisfactory or uniform manner without the use of a mechanical mixer. If two blocks are laid side by side, manufactured from the same basic materials, one from a mixture that has gone through a well designed mixer, and the other mixed by hand, or more properly by the use of the shovel, the difference will be easy to detect, and the quality of the stone, where everything else is equal, loudly proclaims that a good mixer is the cheapest thing about a concrete plant."

The Clover Leaf Mixer when fitted for power is without wings, vanes or deflectors; it has no inside mechanism. It has three simultaneous mixing movements, not rolling or sliding to a common center but a compound scattering motion, causing distribution from three distinct angles at once. The Clover Leaf Mixer is provided with a large door in the side of the drum, thus making it of instant and easy access to all parts of its whole interior. The machine is fed and discharged while running. The discharging may be partial or entire, as the operator may elect. It is light in weight, its extreme simplicity allowing of a design for construction that avoids causing the machine to be in any sense cumbersome. It is probably the lightest high grade batch concrete mixer on the market. Every Clover Leaf Concrete Mixer, whether for hand or power, is sold under our absolute guarantee that it must be perfectly satisfactory to the user or it may be returned to us at our expense and your money will be refunded.

A Perspective of the Mixing Receptacle

The Clover Leaf Concrete Mixer having no inside mechanism, the charge it contains is allowed to pass freely over the inside of the mixing receptacle, and the angles being in line of the movement of the materials, are constantly scoured by the action of the moving mass. In this machine there is no possibility of the heavier and lighter aggregates becoming separated; the entire mass commingles during the process of mixing, assuring uniform concrete of the highest order, both as to the proportioning of the fine and coarser materials and the even distribution of the cement. It has a unique mixing receptacle which oscillates from end to end.

The unique form of the mixing receptacle of the Clover Leaf Concrete Mixer insures a full and complete intermixing of the mass without the aid of appliances or mechanism of any description. The curves or angles of the drum positively double over the greater portion of the mass, the top going to the bottom and the bottom brought to the top, while the remainder is carried up by the same angles, aided by the centrifugal force of the machine, effectively distributing same the full width of the machine and over the portion previously doubled over, giving practically six distributions to the mass every revolution, allowing from eighty to ninety distributions per minute.


Sectional View of Drum, Showing Material Being Mixed While Drum Revolves

The mixing receptacle of the power mixer is oscillated from end to end twice each way each revolution of the machine, or from fifty to sixty end to end movements per minute. These end to end movements, together with the doubling over and carrying across of the concrete by the direct action of the machine, assures a most positive and thorough intermixing of the mass, and that in the minimum time.

Under many varied conditions, most severe tests have been made on this machine, until we have thoroughly, by practical application, demonstrated our rights to the claim of excellency and superiority herein claimed. Nothing has been left to the purchaser but the acceptance of the machine under our positive guarantee that it will perform its work as represented, otherwise the machine may be returned to us.

THIS BUILDER IS PROUD OF THE X-L-ALL CEMENT BLOCK MACHINE.

GEORGE E. HALL,
Practical Roofer and Repairer.

Sterling, Ill., Dec. 1, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I bought an X-L-ALL Cement Block Machine from you and have made several thousand blocks for myself and others. There are several machines in Sterling but there are none that makes as good or satisfactory blocks as my X-L-ALL machine, 8x8x16-inch blocks. The masons and contractors agree with me that those blocks are the best size and our home architect says they are the best size and also the best looking blocks manufactured in Sterling, and the rock face is the most natural and looks more like cut stone than any block he has ever seen. I wish to say we had but very little trouble in starting to make blocks, and broke but very few. We found that if we dampened or wet the sand and cement too much they would break, but by experimenting we got out some of the finest blocks you ever saw, and I am proud of the X-L-ALL Cement Block Machine. I hired two good men and after they got about three days' experience I had to get a lot more pallets and from that time they make 200 blocks every seven hours. Another thing, your X-L-ALL Cement Block Machine makes the face of the block on the bottom of the mould, which gives a person a chance to put in better material for the face, which I find makes the blocks as waterproof as the hardest brick, and by using white sand and white cement for about half an inch on the face, makes a white faced stone. I will want some attachments for bays, angles and gables in the spring and think I will put in one and perhaps two more X-L-ALL Cement Block Machines. I will also have to get one of your machines for caps and sills and water tables.

Respectfully, GEO. E. HALL.

JUST AS GOOD AS MACHINES SOLD FOR $200.00 AND $300.00.

Marion, Ind., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I have had the X-L-ALL Cement Block Machine about ten weeks and in that time I have made about 2,500 blocks. I find the machine to be all you recommend it to be. In fact, it is a little dandy. Everyone that sees the machine thinks it is a good machine. I have not built any houses made of cement blocks made on your machine, although I have put in several foundations. I understand that you have a new attachment for the X-L-ALL Machine to make blocks 8x10x16 inches and 8x12x16 inches. That is a grand improvement for foundations, and the first story of a cement building should be made out of blocks 8x10x16 or 8x12x16 inches. The second story can use 8x8x16-inch blocks. I am going to buy one of your new attachments for my machine. I am also going to make an attachment for my machine to make cement brick. There is some demand for cement brick in this locality.

I cannot say too much for your X-L-ALL Cement Block Machine, as it is just as good a machine as other manufacturers wanted from $200.00 to $300.00 for. I have made twelve blocks in fifteen minutes with your machine. I had one man to feed the machine, one man to tamp and to operate the machine and one man to carry away the blocks. I would like to see a machine that can make first class blocks faster than that. I make my blocks out of a sharp screened gravel with just enough sharp sand to make the block compact. I use for the face one part cement to two parts of very fine screened sand, glass sand is best for face, and for concrete in blocks I use one part cement to five parts of gravel and sand. Please send me your new Cement Catalogue as soon as possible.

Yours respectfully, G. W. PEPPLE, Contractor and Builder.

The Clover Leaf Hand Power Mixer

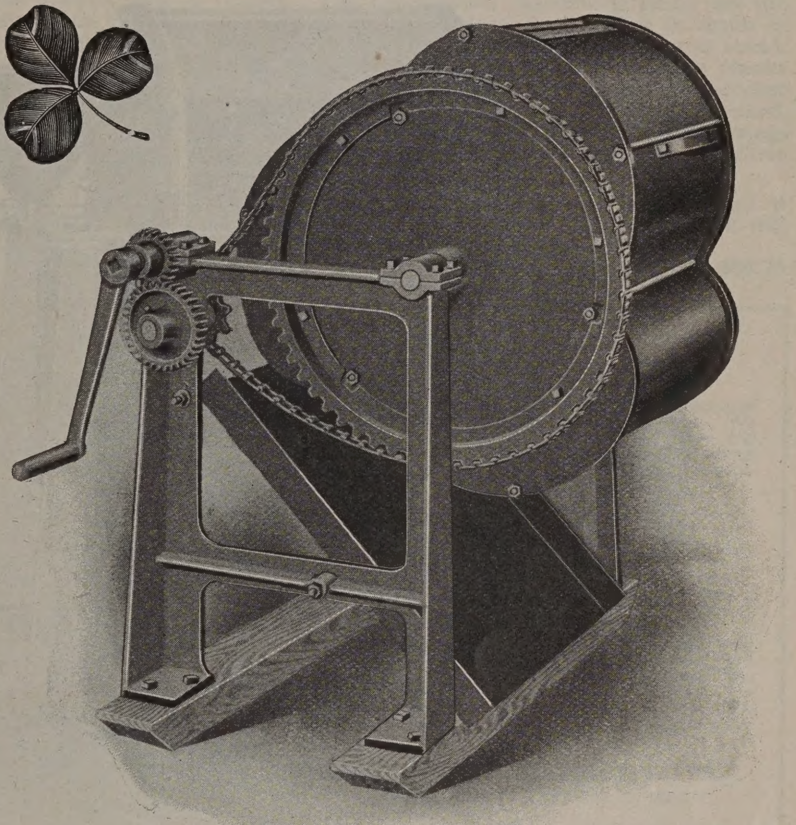
This machine should be given about a dozen revolutions before the water is applied and about the same number of turns after the water has been turned in.

THE MIXER WORKS TO PERFECTION.

Mr. J. S. Grue, Tekamah, Neb., writes as follows:

Gentlemen: — Wired you tonight. "No. 4 Mixer works to perfection. Will mix batch thoroughly in two minutes, dry mix." Two cement men were present when I mixed first batch and each a doubting Thomas as to a mixer doing thorough work without some inside mechanism. Two minutes only were required to change their opinions, both pronouncing the work of your machine as perfect.

The capacity of the Clover Leaf Hand Power Mixer is about 3½ cubic feet. With this capacity best results will be obtained by using two men to operate the machine.

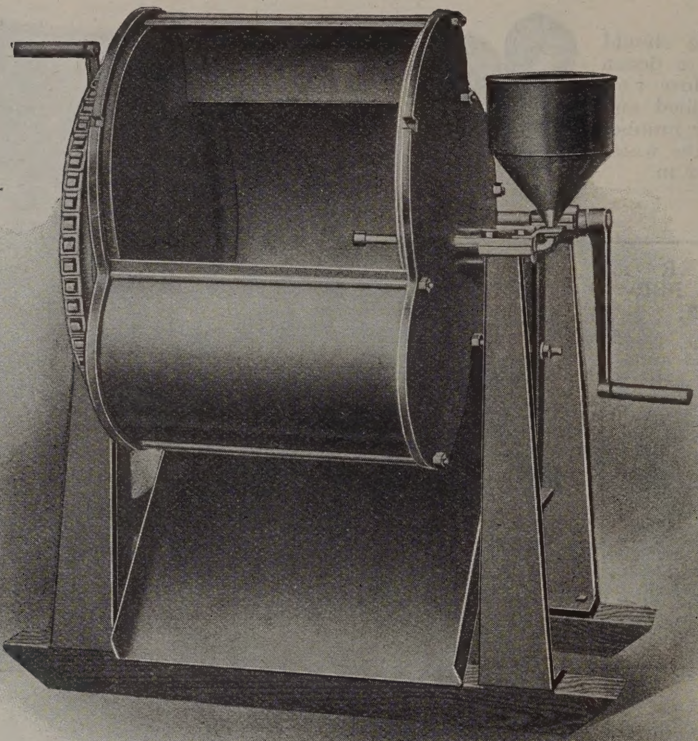


The above illustration shows the Clover Leaf Hand Power Mixer with its load discharged, again filled, the door put back in and the machine ready for another mix

The Clover Leaf Hand Power Mixer

The mixing receptacle of the Hand Power Clover Leaf Concrete Mixer is the same form as that used on the power driven machines. By the use of this form of mixing drum, a perfect mix can be performed regardless of how slowly the mixing receptacle may revolve, as the material is positively doubled over (not rolled), the top going to the bottom and the bottom to the top several times, for each revolution of the drum. This is accomplished regardless of the speed at which the machine is operated, and is a very important advantage, as a hand machine can be operated only at a slow speed. We have provided interchangeable gears so that the machine can be operated easily by one man. However, the mixer is equipped with two cranks so that you can reverse or change the gears from one stud or shaft to another and operate it with two men, if so desired. The cranks are heavy and strong with an 18-inch sweep. The steel shaft to which the cranks are attached, is made of cold rolled steel, 1½ inches in diameter and 48 inches long, and is turned down to 1 7/16 inches for the bearings. There are five babbitted bearings, 4 inches long. Two of these carry the steel shaft, which is 1½ inches in diameter and carries the steel drum or mixer. There are two bearings on the crank shaft and one bearing on the stud or gear shaft to which a small sprocket wheel is attached. The drum or mixing receptacle is driven by No. 63 link chain belting. The large sprocket wheel, which is securely bolted to the end of the drum or mixing receptacle, has 58 gears for this chain and the sprocket wheel on the stud or gear shaft has 20 gears, while the smaller sprocket wheel on the crank shaft has 8 gears. These two smaller gears are interchangeable.

Clover Leaf Hand Power Mixer



The above illustration shows the Clover Leaf Hand Power Mixer with the door of the cylinder or drum removed ready for discharging and reloading

FOR charging and discharging the machine a door is removed as shown in illustration. The opening is at a convenient height for getting material into the machine and for discharging, the drum is revolved, bringing opening to a point where all material falls on a chute provided and drops to the floor, where it is easily accessible for use. The material is removed and kept away from the ends of the drum by means of deflectors so placed at the ends as to make them effective in working the material toward the center of the drum, assuring an intermix of the charge. These answer the purpose admirably, and their use enables us to reduce the cost of this type of machine and produce most satisfactory results.

The cylinder or drum of the Clover Leaf Hand Power Mixer is made from 14-gauge cold rolled sheet steel, securely fastened to the two heavy cast iron heads or ends by means of seven rods, 5/8 inch in diameter. The outside length of the drum or cylinder is 28 inches, the inside length of the drum is 24 inches and the inside diameter of the drum is 28 inches between the two widest points.

The Clover Leaf Hand Power Mixer is mounted on a heavy cast iron stand, the legs are 6 inches wide at the bottom and taper to 3¼ inches wide at the top. The height of the cast iron stand is 37 inches and it is mounted on two heavy skids, 3¾ inches thick by 5½ inches wide and 53 inches long. The stand is securely bolted to the skids by lag screws and the top of the stand is well braced by a heavy cross piece with an under brace, and the babbitted boxes or bearings are securely bolted on the top of the stand. The stand is further reinforced by the heavy steel shaft extending clear across the machine and also by two heavy brace rods, 5/8 of an inch in diameter, carried across near the bottom. The steel apron is fitted to the stand under the drum or cylinder and is made from 18-gauge steel.

Water is applied to the mixture as wanted and in such quantities as needed by means of a ½-inch iron pipe extending into the center of the drum. This pipe is perforated to allow an even distribution of water. The Clover Leaf Hand Power Mixer is furnished with a heavy galvanized steel funnel with regular ½-inch gas pipe connections. Where water pressure is used, remove the funnel and attach thereto hose or water pipe, which should be fitted with a cut-off to adjust the flow of water required.

The Clover Leaf Hand Power Concrete Machines are shipped knocked down, that is, we detach the cylinder or drum, pack the two cranks, sprocket chain, water tank, fittings, etc., inside of the drum. This obtains a lower rate of freight. The hand power machine is easily set up, and if you are not provided with a tackle block you can easily place the cylinder or drum in position by using two good, heavy planks. Place the ends of the planks on the top of the frame or stand, allowing them to stand out in front of the machine, then roll the drum or cylinder by these planks or skids on the axle of the drum until it is placed into position. Use care in putting on the sprocket chain. Sprocket chain should be put on with the open or claw end of the link facing upward. The spur of the sprocket wheel should enter the chain ahead instead of pulling it. The bearings of these machines are babbitted, and the machines are painted with a good steel gray machine paint. From 20 to 25 revolutions mix the material thoroughly.

Every machine is guaranteed to be perfect in construction, workmanship and material, and if not found satisfactory after ten days' trial, it may be returned to us at our expense and we will refund every cent of money paid, including freight charges.

No. 63A2301 Clover Leaf Hand Power Mixer. Weight, 775 pounds. Price.......... **$56.75**

FOUND THE X-L-ALL JUST AS WE RECOMMEND IT.

Statts City, Mo., Dec. 1, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Yours of the 26th ult. at hand. As to my experience with the X-L-ALL Cement Block Machine I purchased from you, will say I ordered the machine for my neighbor but helped him work the machine. We found it just as you recommended it, both in workmanship and ease of operation. Three of us made 150 blocks in ten hours with the machine. I expect to buy one of the X-L-ALL Cement Block Machines about March. I wish you would send me some designs of four and five-room flats also designs for churches and schoolhouses. Respectfully yours, J. J. SPRINKLE.

CONSIDERS BLOCKS MADE IN THE X-L-ALL SUPERIOR TO ANY.

Glidden, Iowa, Dec. 2, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I received the extra castings to replace those broken in shipping and I wish to thank you for the same. I received the X-L-ALL Cement Block Machine so late this fall that I was able to make only a few blocks. I wish to say, however, that I am well pleased with the machine. It makes a good block. It makes the right sized block and, what I consider most important of all, it makes them face down.

I put about an inch of sifted sand and cement in the bottom of the mould and then fill up with sand, gravel and cement, thus making a stronger block and a cheaper block than where just sand and cement alone are used. The blocks I have made I consider superior to anything I have seen. The machine works rapidly and easily and looks as if it would last a lifetime. As to whether or not moisture will collect on the walls of a building made of cement blocks, I cannot say. I, however, have the word of a man who lives in a house made of cement blocks and plastered directly on the blocks, who says there is absolutely no moisture on the walls. Very truly, FRANK EVARTS.

DISCARDS A HIGH PRICED AUTOMATIC MACHINE AND WILL USE THE X-L-ALL.

Patchogue, L. I., N. Y., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—The X-L-ALL Cement Block Machine I purchased from you some time ago is the best machine I have seen so far. While waiting for some parts, to take the place of some broken by the railroad company, I purchased the ———— Automatic Machine, which manufactures blocks of all sizes. This machine, I find, is too slow and expensive and in the spring I shall use your machine. The blocks from your machine are in great demand as they are the most economical and the easiest to handle. Your truly, JOS. DE PIAZZY.

THE X-L-ALL EQUALS THE OUTPUT OF A $125.00 MACHINE USED BESIDE IT.

Gate City, Va., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I purchased an X-L-ALL Cement Block Machine from you last June and since that time have made several thousand good blocks. I have two machines, one of which is the ————, which cost me over $125.00, and I run them both side by side and make about the same number on each machine. With the two machines we have made about 20,000 blocks this season and I am now building myself a cottage of blocks made almost entirely on your X-L-ALL machine. Yours truly, G. B. DARTER.

THE X-L-ALL MEETS EVERY REQUIREMENT.

Corfu, N. Y., Oct. 15, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—After giving your X-L-ALL Cement Block Machine, size 8x8x16 inches, a most thorough test, I am more than pleased to inform you that it has met with my hearty approbation and it has filled all of the requirements as represented by you. Very respectfully, E. HERINGTON.

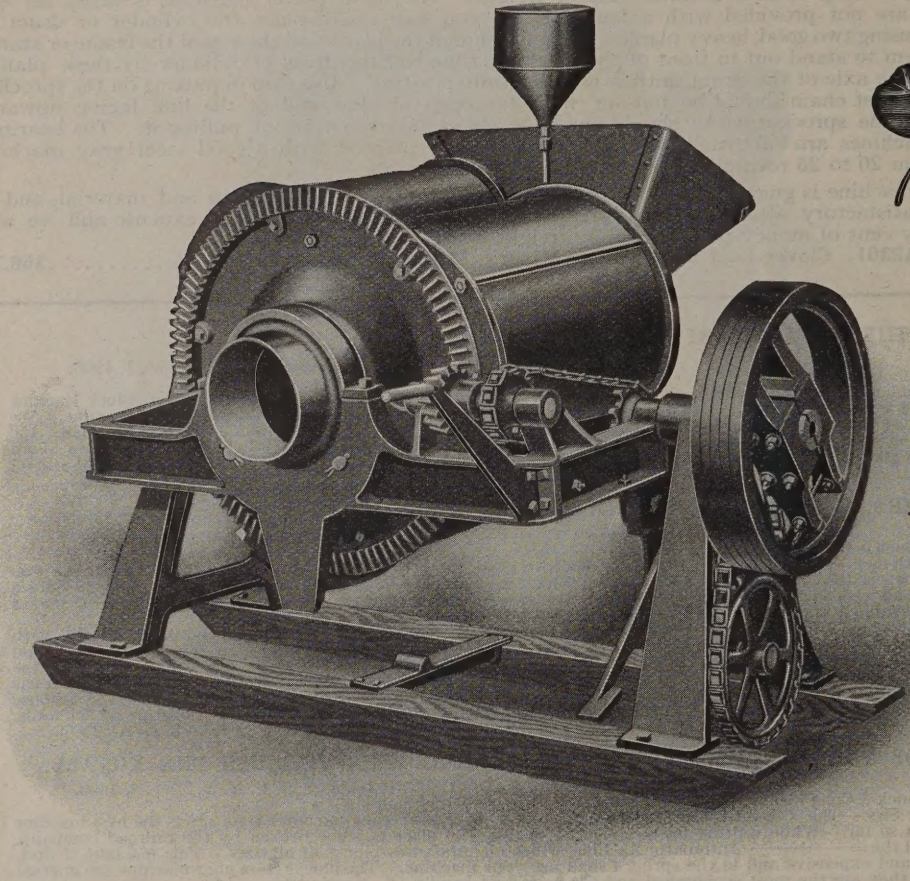
DOES NOT SEE HOW THE X-L-ALL COULD BE IMPROVED.

Fitzgerald, Ga., Dec. 14, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—It affords me pleasure to report to you that the X-L-ALL Cement Block Machine that I ordered from you came in due time and so far as I have operated it I am more than pleased with the work it does; in fact, I do not see how it could be improved. There is probably a dozen kinds of block machines in this city, but I do not see any that I like as well as the X-L-ALL. It is easier to operate and makes fully as good blocks, and I think speedier than any of them. There are a great many houses in this city constructed of cement rock, both business blocks and private residences, postoffice and several warehouses, all plastered on the walls without lath. I fail to hear any complaint of damp walls. Yours truly, D. BURNETT.

Clover Leaf Power Mixer



The Above Illustration Shows the Clover Leaf Concrete Power Mixer on Skids

THE above illustration shows our No. 4 Clover Leaf Concrete Mixer fitted with pulley for power and mounted on skids ready for operation. The illustration on the following page shows the same machine in another position. The size and capacity of this power mixer is given in loose dry material when worked into wet concrete. The regular charge contains about 4½ cubic feet. This machine when operated at a good fair average speed has a capacity ranging from 25 to 35 cubic yards per day of ten hours. This speed and power is based on two-horse power, which is the most satisfactory. We show this machine on skids only, but it can be furnished on trucks if desired. The length of the drum is 28 inches and the inside diameter of the drum is 34 inches between the two widest points. The diameter of the mouth or opening in front for discharging the load is 10 inches. The diameter of the inlet for receiving the load on the rear of the machine is 9 inches. With the machine we furnish a hopper which is attached to the rear of the machine and it is 20½ inches wide by 32 inches long. This hopper is designed to assist you in loading the machine. It is made of No. 16-gauge galvanized sheet steel reinforced by bar iron ¼ inch thick and 1 inch wide. This hopper is well made, rigid in construction and well designed. As shown in the illustration, this machine oscillates backward and forward and the hopper tilts with the machine and is raised and lowered from 40 inches at the lowest point to 60 inches at the highest point.

This hopper is especially designed for enabling you to load the drum or cylinder by the use of a wheelbarrow. To do this, erect a runway and scaffold from your supply yard to the rear end of the machine, building it to the proper height to enable you to dump your concrete into the hopper direct from the wheelbarrow, saving the expense of handling. This feature is especially desirable on any large job of work and is always used by large contractors in bridge work, foundation work, retaining walls and other heavy work where there is very much concrete work to be done.

The drum or cylinder of the Clover Leaf Power Mixer is carried on two drill rod bearings at each end, 4¼x1¼-inch base and 1½-inch shaft. The cylinder or drum is made of No. 12-gauge cold rolled steel. The heavy cast iron head is 34 inches in diameter. To this massive head is bolted a gear wheel which operates with the spur gear engaging with a bevel gear driven by a sprocket chain made of No. 62 link chain, pulling over a sprocket wheel with eleven teeth.

The diameter of the large gear wheel on this size of machine is 31 inches. The gears are all 2-inch face. The shaft carrying these gears works in 2½-inch babbitted bearings.

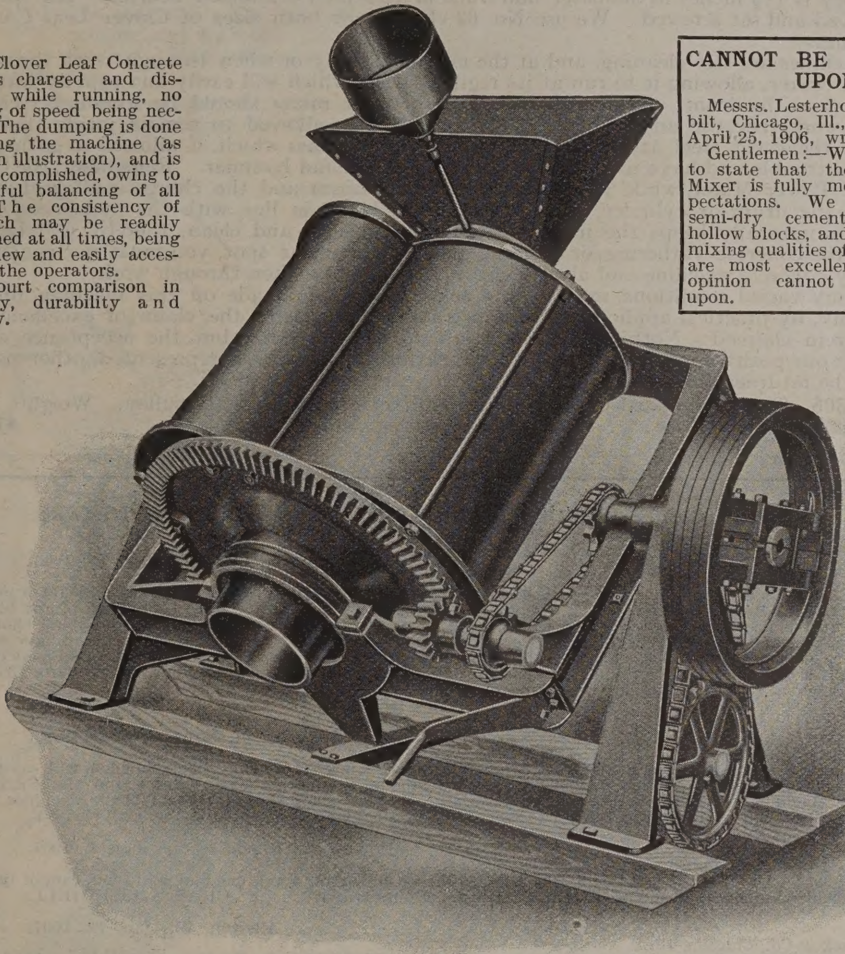
The Clover Leaf Concrete Mixer is charged and discharged while running, no lessening of speed being necessary. The dumping is done by tilting the machine (as shown in illustration), and is easily accomplished, owing to the careful balancing of all parts. The consistency of the batch may be readily determined at all times, being in full view and easily accessible to the operators.

We court comparison in simplicity, durability and efficiency.

CANNOT BE IMPROVED UPON.

Messrs. Lesterhouse & Vanderbilt, Chicago, Ill., under date of April 25, 1906, write as follows:

Gentlemen:—We are pleased to state that the Clover Leaf Mixer is fully meeting our expectations. We are mixing semi-dry cement mortar for hollow blocks, and find that the mixing qualities of your machine are most excellent and in our opinion cannot be improved upon.



Position When Discharging

The Clover Leaf Concrete Power Mixer as shown herewith is mounted on heavy wood skids, 3½ by 5½ inches and 7 feet long. To these skids are bolted the heavy cast iron stands or ends which are about 7 inches square at the bottom and taper up to about 3½ inches at the top where the axle shaft is bored. The Clover Leaf Concrete Power Mixer is designed and built to obtain an oscillating motion by means of a cam which works on a 1½-inch wrist pin. The construction of these parts insures great strength and ease of operation and perfect results. With this machine we furnish a wood pulley with 3½-inch face and 24 inches in diameter. The heavy steel sides of the drum are firmly secured to the cast iron ends by means of eight steel rods, ⅝ of an inch in diameter, running lengthwise through the drum.

The machine when ready to discharge its load is brought to its tilting position by the operator tripping the cam lever and pressing down on end lever, when the machine will tilt forward of its own accord and remain in this position, constantly revolving until every particle of the load is discharged. The machine is then easily raised back into position and again loaded. In the meantime, understand that the machine is not stopped at any stage of the operation, the power being applied continually from morning until noon or noon until night, it being loaded and discharged at the same speed at which the mixing is done.

The Clover Leaf Concrete Power Mixer should be operated with a 1½, 2 or 3-horse power engine. Usually a two-horse power engine produces the best result. With the machine we furnish a 24-inch wood pulley, which should be run at ninety revolutions per minute, which will give thirteen revolutions to the drum. The size of pulley used on the machine should be based on the size of pulley on your engine or countershaft. If you are operating with a gas or gasoline engine, you can drive direct by clutch attachments or you can use either sprocket chain or pulley and belt power. We furnish the machine, however, with a wood pulley 3½-inch face and 24 inches in diameter, as mentioned above. Your countershaft or pulley should be applied accordingly. The shaft carrying this drive pulley is 1½ inches in diameter and runs in an 8-inch babbitted bearing. All sprocket wheels are keyed and set screwed. We use No. 62 chain with both sizes of Clover Leaf Concrete Mixing Machines.

These machines are self cleaning, and at the end of the day or when through work throw in a few buckets of water, allowing it to run at its regular speed which will easily and rapidly wash out and perfectly clean the drum. Remember, the drum of your mixer should be thoroughly cleaned after a day's work, because any cement or concrete that is allowed to remain inside the drum will adhere to the sheet steel at certain points and form a mass which, if allowed to gather, will soon cause you trouble and have to be removed by cold chisel and hammer. Remember, the Clover Leaf Concrete Power Mixer, while it has no inside mechanism and the charge is allowed to pass freely through the drum or cylinder, the angles always being in line with the movement of the concrete which naturally keeps the inside of the drum bright and clean, thereby avoiding the possibility of the concrete gathering or forming in any particular spot, you must not neglect the interior of any concrete machine and always clean it thoroughly when through work.

Under many varied conditions, most severe tests have been made on this machine, until we have thoroughly, by practical application, demonstrated our rights to the claim of excellency and superiority herein claimed. Nothing has been left to the purchaser but the acceptance of the machine under our positive guarantee that it will perform its work as represented, otherwise the machine may be returned to us.

No. 63A2305 The Clover Leaf Concrete Power Mixer, on skids, with pulley. Weight, complete, 1,400 pounds. Price........ **$113.50**

THE BUCKEYE CEMENT BLOCK MACHINE PLEASES THESE CUSTOMERS.

M. W. ADAMS, General Contractor.
Satisfaction Guaranteed.

Johnston City, Ill., Dec. 15, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—After examining several makes of concrete block machines, ranging as high as $135.00 in price, I decided to try your Buckeye Cement Block Machine. I find it to be the best and most convenient of any block machine for good blocks, quick delivery and economizing in space to operate, as it is simple and small enough to handle with ease and large enough to do the work. I would not exchange for any other machine I have seen, and I have seen quite a number that cost twice the amount of mine. As I work in several towns and have contracted for years, ever since 1890, I think I know what I am talking about when I say your machines are all you claim for them, equal to any of the high priced machines and better than a great many of them.

Yours truly, M. W. ADAMS.

Long Island, Kans., Dec. 28, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your letter as to how I like your Buckeye Cement Block Machine, will say that your machine makes as good and strong a block as any machine on the market at any price and the Buckeye Cement Block Machine is easy to operate and very speedy. I have seen several cement block machines and compared the work, but give me the Buckeye Cement Block Machine. Yours truly, C. I. COLBY.

Providence, Rhode Island, Jan. 7, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—The Buckeye Cement Block Machine is an extra good machine and you cannot quote me too strong in favor of it. I am well pleased with it. Yours truly, CHAS. A. SETCHELL.

Allerton, Ill., Jan. 12, 1907.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your letter asking how I have succeeded with the Buckeye Cement Block Machine, I wish to say that I ordered the machine so late that I can only make a few blocks before cold weather sets in. I made blocks for a foundation job before the season closed and the machine is O. K. I am well satisfied with the outfit.

Yours truly, D. S. DEAVERS.

Bronston, Minn., Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I have made blocks with your Buckeye Cement Block Machine purchased from you some time ago and find the machine all right in every respect. It might interest you to know that I have another cement block outfit that cost about $800.00 (eight hundred dollars). We can do the work more satisfactorily in every way with the Buckeye machine. I think I can give any person that never used a block machine some useful pointers and anyone writing to me and enclosing a stamp, I will tell them my way of handling the block business. I got started too late to get a building put up of Buckeye cement blocks, but in this country would advise the use of lath and plaster on the inside walls.

Yours truly, ROBERT A. RUBERT.

N. E. TALBOT,
Building Contractor and Jobber.

Willoughby, Ohio, Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

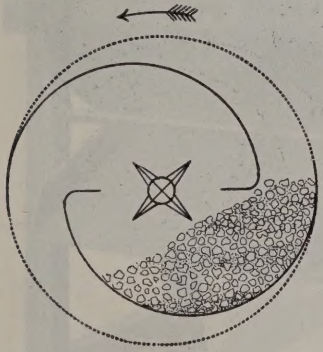
Gentlemen:—Yours of the 26th ult. to hand. I would say that I am very well pleased with your Buckeye Cement Block Machine. The machine makes a good block, and one good man with things handy can turn out from 75 to 100 blocks per day. The machine is as good as the best hundred dollar machine. I have not yet used many of the blocks but expect to use them the coming season for foundation and porch work.

Yours truly, N. E. TALBOT.

X-L-ALL Hand and Power Concrete Mixers

THE X-L-ALL Concrete Mixing Machine will mix a batch of concrete more thoroughly than can possibly be done by hoes or shovels. Another important feature in the larger sized X-L-ALL Concrete Mixing Machines is the perforated shaft extending through the cylinder of these machines, which makes it possible to secure great efficiency in applying water to the concrete. The amount of water should be perfectly distributed at all stages during mixing and with this perforated shaft water may be used in such quantities as are desired. You control the supply of water by means of a pet cock between the water tank and drum.

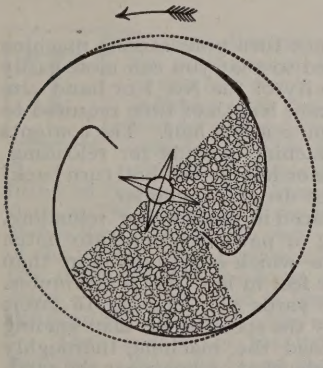
The illustrations herewith show the position of the concrete during the revolutions of the drum. In other words, at the time the drum is being loaded the bases of the two wings are parallel to each other, enabling you to load the drum to its full capacity; then follow the line of mixture as it appears when the drum is being turned over, as shown in illustration No. 2. See how the mixture is shifted from the bottom of one wing across the entire width of the drum or cylinder. At no time during the operation is the batch rolled over, instead it is continually thrown from the bottom of one position to the center or farther side of the drum. This occurs twice with each revolution of the crank. Can any feature produce results that would be nearer mechanical perfection? Cement is in every case the more expensive portion of concrete and is the life of the finished product, therefore it is of the greatest importance that the proper proportions of cement should be used to insure the greatest life to concrete and the cement must be thoroughly distributed among the aggregates to secure perfect results.



LOADING

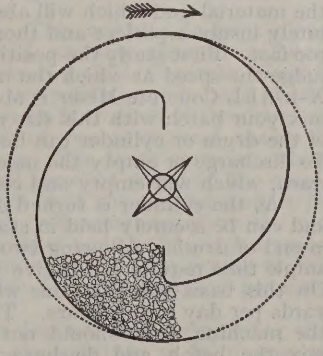
This illustration shows the position of the drum of the machine while loading the material into it. Note how evenly the machine is balanced while the load is being put into the drum or cylinder. The X-L-ALL Concrete Mixer is quickly loaded and discharged.

Every particle of gravel, crushed stone and sand, no matter how small or how large, must be perfectly covered with a coating of cement in order to form a perfect mass which, when properly set, will make a lasting wall or block. This can only be done by thoroughly mixing the dry cement with every particle of sand and gravel before the water is applied, and the same care should then be exercised to see that every particle of cement has just enough water to enable it to perform its part of the work. The amount of water required to produce the best results can be determined as the mixing proceeds. The condition of the materials has much to do with the amount of water required. Your sand might be very dry and have a considerable amount of fine dirt or dry matter in it which would require more water to moisten than if the sand were fresh as when removed from the pit. Crushed stone that has been well screened and does not contain much dust will require very little water to enable the cement to properly adhere to it, therefore the necessity that the batch be constantly visible to the person operating the machine or supplying the water. Concrete should not be mixed in large batches and left to stand. Freshly mixed concrete will always produce the best results, therefore the X-L-ALL Concrete Mixers have been built with a view of speedily mixing a reasonable batch of concrete and having it ready for use in the shortest possible time rather than to increase the size and capacity of the machine, thereby increasing the size of the batch mixed, which, in order to operate, reduces the real efficiency of the work for which the machine is intended.



MIXING

This illustration shows the contents of the drum while being mixed. Note the material from the outside of one of the wings falls to the center of the machine, where it comes in contact with deflecting bars before passing into other wing, thus breaking and mixing the material as the machine continues to revolve. The material on the bottom of one wing is transposed and at the end of the revolution it rests on the top of the opposite wing. This operation is repeated as the cylinder revolves.

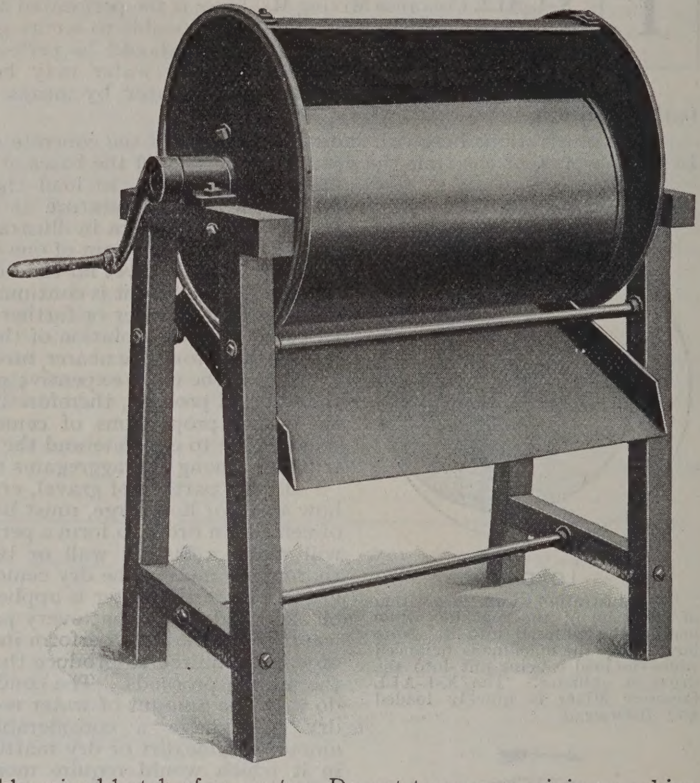


DISCHARGING

This illustration shows the position of the drum or cylinder when discharging the load. Note that every particle of concrete within the cylinder is discharged by simply reversing the motion of the drum by a half turn. No covers or sides to remove in loading or discharging the material.

The X-L-ALL Concrete Mixing Machine

Hand Size No. 1



THIS machine is especially adapted for the concrete block and brick machine where only a small amount of work is done. The wood frame or stand for this mixer is made of hardwood timbers 2½ inches square. The cylinder or drum of the machine is made of No. 14-gauge cold rolled sheet steel and is 24 inches in diameter and 32 inches long. The main shaft extending through the center of the machine is 42 inches long. This shaft turns in two heavy cast iron boxes or bearings, 3½ inches long by 2½ inches in diameter. The height of the machine from the floor to the center of the cylinder is about 40 inches, which is the height that the material has to be shoveled. This machine is fitted with a 1-inch iron pipe extending the entire length of the cylinder or shaft Six turns of the crank after the mixture is first put in make more than twelve different changes or mixtures of the material in the drum, which insures a thorough mix. Now apply the water and give it an equal number of turns, which will double the number of changes of the material and which will absolutely insure a perfect and thoroughly mixed batch of concrete. Do not turn your mixing machine too fast. First study the position of the concrete while it is being mixed so that you can more easily judge the speed at which the machine should be operated The capacity of the No. 1 or hand size X-L-ALL Concrete Mixer is about 2 cubic feet to the batch. The average length of time required to mix your batch with this size machine is about one minute or one minute and a half. The contents of the drum or cylinder can be almost instantly discharged and the machine is ready for reloading To discharge or empty the machine, reverse the motion, turn the crank or handle one-half turn backward, which will empty and clean out one entire wing or section of the drum or cylinder.

As the cylinder is turned backward and discharged it is being placed in position for reloading, and can be securely held in stationary position for reloading by a dog or pawl dropped into notch in end of drum. Allowing two minutes to fill or reload the machine which is perhaps more than ample time required, will give you a mixing capacity of about 2 cubic feet in less than five minutes. On this basis your machine will have a capacity of about 1½ cubic yards per hour or 15 cubic yards per day of ten hours. This work, however, may be increased by the speed of the man loading the machine, as it should not require more than two minutes to load the machine, thoroughly mix the batch and discharge the same. This would also depend somewhat on how near the sand, gravel, cement, etc., are placed to the work.

No. 63A2501 The X-L-ALL Hand Size or No. 1 Concrete Mixer, capacity about 25 yards per day. Weight, 300 pounds. Price.. **$20.50**

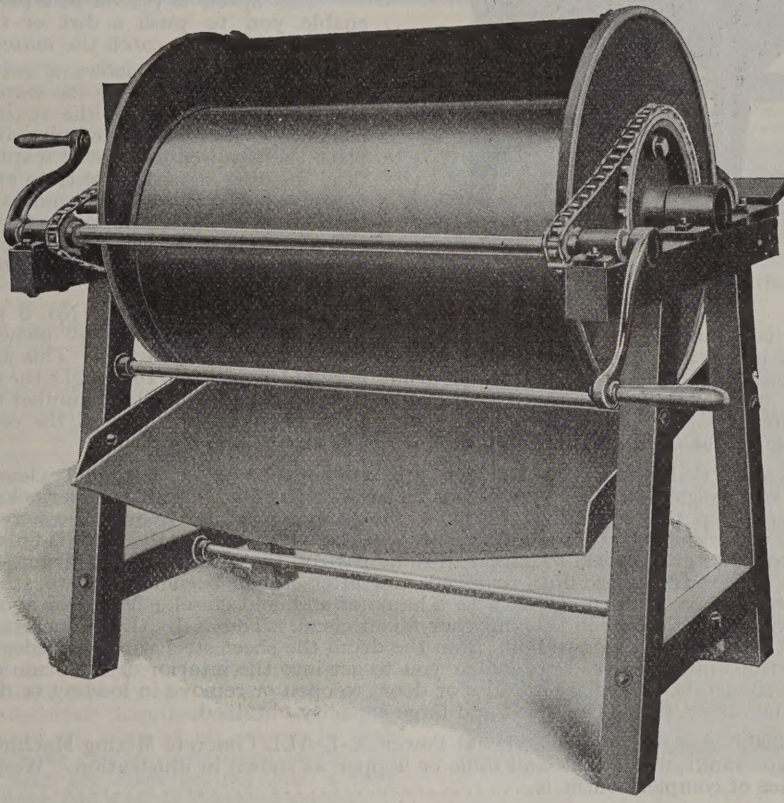
RECOMMENDS OUR BLOCK MACHINES TO ANY CONTRACTOR.

87-89 Fleet St., Jersey City, N. J., Dec. 7. 1906.

Sears, Roebuck & Co., Chicago, Ill

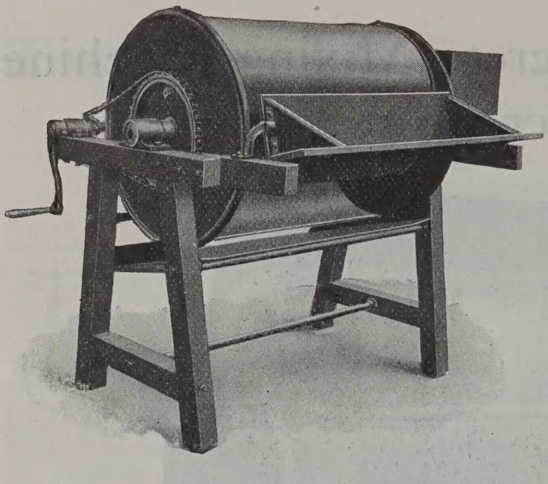
Gentlemen:—The block machine we purchased from you is perfectly satisfactory to us and we can recommend it to any contractor in the market for block machines. We are more than pleased with our machine. We have used the blocks for building porches, piazzas and walls. Yours truly, STEUP BROTHERS.

The X-L-ALL Concrete Mixing Machine Hand or Power, Size No. 2



THE above illustration shows a front view of the machine. This machine is built along the same general lines of construction as the No. 1 X-L-ALL machine, except it is larger in size and much heavier in construction. The No. 2 size X-L-ALL Concrete Mixer is fitted up with two cranks so that it may be operated by two persons and is back geared four to one and is driven by a No. 45 steel sprocket chain on both ends of the drum or cylinder. This feature alone insures strength and ease of operation and makes it absolutely impossible for any side draft in the bearings. The large sprocket wheel fitted on the end of the drum is 11¾ inches in diameter and the small sprocket wheel on the crank shaft is 3½ inches in diameter. The crank shaft is made of 1 7/16-inch cold rolled steel and is 59 inches long from end to end. The crank shaft is carried in two boxes or bearings fitted on the end of the frame. The main shaft carrying the drum is 3½ inches in diameter and the bearing carrying this shaft is 4½ inches long. This shaft is cast on the ends and extends from the center of the drum or cylinder and is bored to carry a 1¼-inch iron pipe which is perforated for properly distributing the water when mixing a batch of concrete.

The capacity of the machine for a day's work depends a good deal on the persons using the machine. We have found that the actual time consumed in making the mixture is from one to one and a half minutes. It will require less than fifteen seconds to unload or discharge the batch after it is properly mixed, and, allowing two minutes to shovel a new load or charge into the drum, will enable you to make a complete batch of 4½ cubic feet, thoroughly mixed and turned out of the machine, in less than five minutes. On this basis a No. 2 Hand Power Machine will have a capacity of about 2½ cubic yards per hour, or nearly 25 cubic yards per day of ten hours. This work may easily be increased by the speed of the men handling the cement, sand, and operating the machine. You will note on the No. 2 size Hand Power X-L-ALL Mixer that we have provided a feed box on the rear of the machine, thereby enabling you to have one man shovel the material up into this hopper, while the other man is mixing the batch, and after the load has been discharged from the drum or cylinder it takes only a small fraction of a minute to dump a new charge into the cylinder. This gives you almost a continual operation of the mixer. This machine is large enough and its capacity great enough to mix more than enough material to keep two cement block



machines supplied with concrete, and three men can easily produce with this machine a capacity of 50 to 60 yards a day. All of these machines are provided with a sheet steel apron securely fastened to the frame directly under the drum to catch and convey the batch of material when dumped from the drum.

This apron is placed at a proper height to enable you to push a dirt or mortar wheelbarrow under it to catch the material.

The illustration shows a rear view of the machine, partly showing the water tank, which is fitted on the end of the machine and connected up with a perforated pipe so that you may place the required amount of water in this tank, thus insuring a perfect wetting of the mixture, or you can disconnect pipe connection leading up to this water tank and put on a hose coupling and attach hose for water pressure. The supply of water can be regulated by a stopcock on the pipe shaft.

The capacity of the No. 2 size X-L-ALL Hand Mixer is about 4½ cubic feet per batch. The drum or cylinder is 32 inches in diameter and about 42 inches long and made from No. 12-gauge cold rolled sheet steel. This machine stands 42 inches from the floor to the center of the drum or cylinder, which is the height the material must be shoveled. Six revolutions of the drum with the mixture dry and a like number of revolutions after the water has been applied will make a total of twenty-four turns of the contents or the mixture inside of the drum. This will insure a perfect mix of the concrete.

The X-L-ALL Concrete Mixing Machines are easily opened up for thoroughly cleaning the inside of the drum and wings. One very important feature which must never be overlooked is the fact that you must keep the interior of any concrete mixing machine free from concrete formations. Any concrete mixer must be thoroughly washed out and cleaned after the work is finished. If small particles of concrete are allowed to gather in some part of the interior of the drum, the formation will continue to increase in size until removed, and after it has been allowed to stand there for a day or two it will have to be removed with a hammer and cold chisel. You can avoid this annoyance by applying a little care in keeping your mixer clean. The X-L-ALL Concrete Mixers are so constructed that by removing two bolts from the drum the sheet steel wings or sides of the mixer can be almost instantly removed to enable you to get into the interior of the drum or cylinder for cleaning it. Remember, there are no sides or doors to open or remove in loading or discharging the batch from the mixer, hence the speed and large capacity obtained.

No. 63A2503 Large, No. 2 Size, Hand Power X-L-ALL Concrete Mixing Machine, complete with two cranks, water tank and table or hopper, as shown in illustration. Weight, 600 pounds. Price of complete outfit is..**$41.50**

We can also furnish the No. 2 size X-L-ALL Concrete Mixing Machine, fitted up with wood pulley 24 inches in diameter with 3-inch crown face, suitable for operating with a 1½ or 2-horse power engine. It is provided with gearing mechanism for the purpose of reversing and stopping the machine to discharge the load. This is done by a jaw clutch operated with a hand lever, thus avoiding stopping the engine or power. The capacity of this machine is probably a little more than the No. 2 size Hand Power Mixer; it being fitted up for belt power means a saving to you of one man, as two men with the use of a small engine will handle and mix from 75 to 100 yards a day. The speed of the back gear or pulley shaft is sixty revolutions per minute.

No. 63A2505 Large, No. 2 Size, X-L-ALL Concrete Mixing Machine. Price, complete, with 24-inch by 3-inch wood pulley and reversing gear for power. Weight, 700 pounds.....**$55.40**

AS A RESULT OF USING ONE MACHINE THIS CUSTOMER BUYS MORE OF THEM.

AMERICAN SUPPLY COMPANY
221 Corcoran Building.

Washington, D. C., Nov. 29, 1906.

Sears, Roebuck & Co., Chicago, Ill.

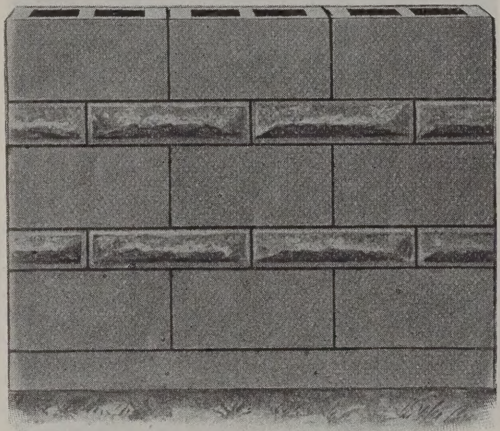
Gentlemen:—In reply to yours of recent date will state that I want to order several more cement block machines and want you to send your special catalogue of these machines. The machine received from you is giving excellent results so far and I intend building several cement block houses of handsome designs. If you could make a side plate for your Buckeye machine so that the cores could be used the same as in your X-L-ALL machine, instead of placing the cores in from the front side of the machine, I would like it as it would be better to place the core in from the rear or opposite side of the machine and use the same pallets. I think this will be a great improvement. We have been experimenting with several formulas for waterproofing the block. Perhaps you can give some information on this subject. Yours respectfully, O. BELLMAN, Jr.

NOTE—Mr. Bellman is using one of our old style Buckeye Cement Block Machines, size 8x8x16 inches, which was formerly made to allow the core to be placed and removed from the front side of the machine. The regular Buckeye, as well as all three sizes of the Improved Buckeye Cement Block Machine, now use a core that is operated from the rear or back wall of the machine.

How to Use Portland Cement

THE foremost chemists and engineers have made thousands of tests, with the most accurate instruments and careful handling have compared notes and verified results, the most important of which are as follows: **A** Portland cement should have only enough water at first to start crystallization. Too much water will "drown" cement. **B.** Water should be fed to the cement as crystallization requires. **C.** Concrete continues to harden with increasing age, and the slower the crystals form the larger and stronger they will be. **D.** Concrete should be made compact, the grains of sand being worked until they set themselves into each other and close the pores. **E.** This is best accomplished by frequent but light tamps. Hard tamping jars and bounces the sand without packing it. **F.** Pressure will not make a good stone, the reason being that when pressure is applied the concrete is at once made compact at the top and bottom in thin layers. These layers effectually form a seal and prevent the air on the inside from escaping and the air is compressed as the pressure is applied. As soon as the pressure is removed the air expands, forces the grains of sand apart and makes a stone that is weak and porous, and therefore easily subject to disintegration. On the contrary, light but frequent tamping works the air out and packs the grains of sand together. **G.** Concrete when first made has no more strength than so much damp sand. If a crack is started while in this condition it will not reunite, but forms a permanent element of weakness; therefore, concrete should not be disturbed after it is moulded or while it is setting.

There are two classes of cement in general use, Portland and Natural. The difference between these two cements is due to the method of manufacture and the contents and real proportions of properties used in manufacturing. In the manufacture of Portland cement the mixing is done by grinding the materials together, after which the mixture is burned in kilns at an extremely high temperature and the cinders or clinkers formed by this excessive heat are then ground into a very fine powder, known and sold as Portland cement.



The above illustration shows a wall laid up of 8x8x16-inch plain face and 4x8x16-inch rock face hollow cement blocks This makes an especially nice wall and is well adapted for churches, schoolhouses, store buildings and any large structure.

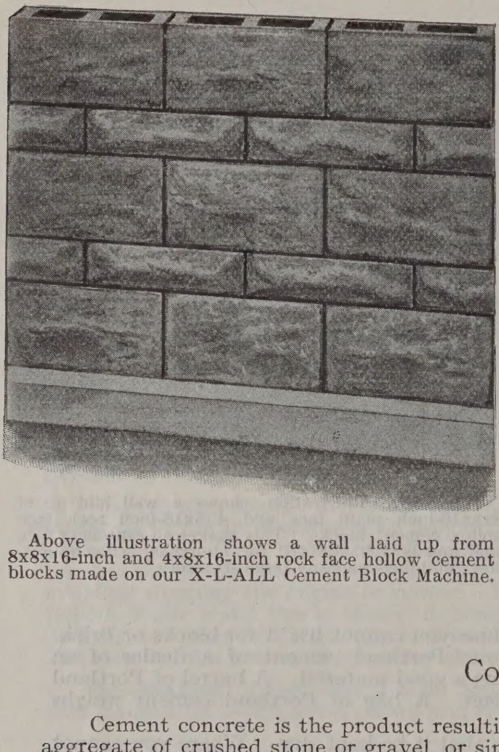
Natural cement is a product found in certain parts of the country and is made of a particular kind of limestone and clay, which, when burned and ground, produces a natural cement, **but it is not intended and must not be used for manufacturing cement block, brick, etc.;** hence, but little mention is made of Natural cement in this catalogue, because you cannot use it for blocks or brick. Use a good, reliable brand of Portland cement Buy your Portland cement of a dealer of an established reputation, so that you will know you are getting a good material. A barrel of Portland cement weighs 380 pounds and contains about 3½ cubic feet. A bag of Portland cement weighs 95 pounds and contains about ⅞ of a cubic foot.

In storing Portland cement you should exercise care that it be kept dry. Where you cannot store it in a house or good, dry building, you may build a platform high enough from the ground to prevent any water from reaching it and see that the bags or barrels are well covered with tarpaulins or a roof to exclude all water. Cement improves with age, but you cannot afford to take any chance of letting it get wet, or it is ruined. Cement, after it has once become wet, is of no value whatever.

Good Material is Essential

You will find that it costs no more to manufacture a perfect block than it does an inferior one from the same material. By following the instructions we give for the mixing of cement, crushed stone, sand, etc., anyone can become successful in making good building blocks. We believe that our machines are producing the very best building blocks made, and we are at all times ready to assist the beginner in this line of work. Remember, the mixture is one of the most important items to be considered. There are differences of opinion as to the correct proportions of cement, sand and crushed stone or gravel to use in producing the best cement block. We have found by experimenting, as well as by diligent search and inquiry among large users of cement, and from many building contractors who have made cement building blocks for several years, that the blocks should be made of from four to five parts of sand to one part of cement, according to the sharpness of the sand. By mixing coarse and fine sand it will be possible to reduce the voids a good deal. The sand should be composed of sharp, angular grains, varying in size. Any coarse grained sand which is fairly clean will give best results. A sand with different sizes of grains is to be preferred because less cement is required to fill the voids. Fine crushed stone is a most excellent ingredient to use with cement and sand. We would recommend one part cement, three parts sand and three parts crushed stone. It should be understood that in using this proportion the sand must be dry and clean. This mixture can also be used wetter than the average mixture. The sand should always be of the very best. It should be screened through a sieve with ¼-inch mesh. Quicksand is worthless and must not be used. River sand as a rule is worn smooth, in other words the grains are round and the cement will not adhere or cling to fine, round sand as it will to coarse, sharp sand. Pit sand will be found to have sharp, angular grains and is the very best for any and all kinds of concrete work. Where it occurs in pockets it should be watched and not too much clay allowed to get in with the sand.

Gravel is plentiful in many sections of the country, known as bank gravel, containing both sand and gravel, which should be screened through the same kind of sieve. You should not use gravel for concrete work which will not pass through a screen having ¾-inch mesh. It is important that gravel used in concrete work should be clean in order that the cement may properly adhere to it and form a solid mass. As with sand, it is well to have the stones of different sizes, which will reduce the spaces or voids to be filled in with cement. The voids in concrete composed of crushed stone, sand and cement will average about 35 per cent of the mass. The best crushed stone for concrete work consists of angular pieces, varying in size from a hazel nut up to a large hickory nut or walnut, but should not be larger and it should have a clean, rough surface. Workers of cement and concrete recommend such rock as limestone, granite, etc.



Above illustration shows a wall laid up from 8x8x16-inch and 4x8x16-inch rock face hollow cement blocks made on our X-L-ALL Cement Block Machine.

Precaution should be taken to cause an even distribution of the varying particles of stone, otherwise your concrete will have too much fine material in some parts and too much coarse material in other parts, thereby having a tendency to reduce the strength of the work. A mixture of crushed stone and sifted gravel makes an excellent aggregate for concrete walls and from some tests that have been published in magazines, treating on this line of work, we learn that crushed stone makes a stronger concrete wall than would sand and gravel alone. Gravel is most generally used because being easy to obtain and cheaper in most cases than crushed stone. One point of value in sand and gravel is that cement blocks or brick will require less tamping to produce a solid mass than is the case where crushed stone is used. The reason that crushed stone is considered stronger than gravel is the fact that there are many rough and irregular sides to the stone which allow the cement to adhere more thoroughly than it would to a piece of gravel that is worn smooth and round by the action of water.

Concrete Work

Cement concrete is the product resulting from an intimate mixture of cement mortar with an aggregate of crushed stone or gravel, or similar material. The aggregate is crushed or screened to the proper size as determined by the character of the work. In grouted foundation work, stone or gravel 2 inches in size may be used to advantage; whereas in the case of moulded articles of small sectional area, such as hollow building blocks, brick, etc., it is best to use only such material as will pass through a ½-inch or ¾-inch screen. A good concrete, from the standpoint of strength and economy, would be that in which all voids in the batch were completely filled with sand, and all voids in the sand completely filled with cement, without any excess. Under these conditions there would be a thoroughly compact mass and no waste of materials. It is a simple matter to determine the voids in sand and also in the aggregate, but in mixing concrete the proportions vary a great deal, depending in each case upon the nature of the work and the strength desired. For example, in the construction of beams and floor panels, where maximum strength with minimum weight is desired, a rich concrete is used; whereas in massive foundation work, in which bulk or weight is the controlling factor, economy would point to a lean mixture. When good stone or gravel is used, the strength of the concrete depends upon the strength of the mortar employed in the mixing and the proportion of mortar to the aggregate. For a given mortar, the concrete will be strongest when only enough mortar is used to fill the voids in the aggregate, less strength being obtained by using either a greater or less proportion. In practice it is usual to add a slight excess of mortar over that required to fill the voids in the mixture.

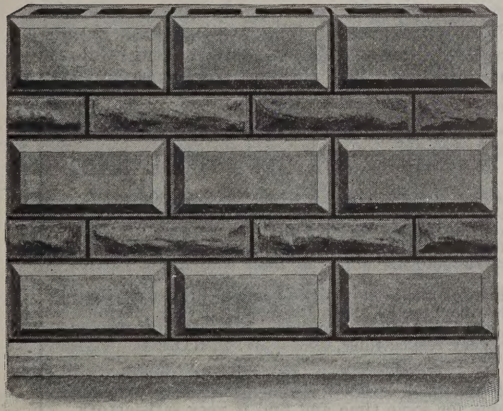
For general use the following mixtures are recommended: One part cement, two parts sand, four parts gravel or crushed stone, for very strong and impervious work. One part cement, two and one-half parts sand, five parts gravel or crushed stone, for ordinary work requiring moderate strength. One part cement, three parts sand, six parts gravel or crushed stone, for work where strength is of minor importance.

In the case of gravel containing sand, or crushed stone from which the small particles have not been removed by screening, the amount of such sand or fine stone should be determined and due allowance made for it in proportioning the mortar. When mixing a batch containing small particles the same conditions obtain as if these particles had been screened from the material and added to the sand used in making the mortar. It is evident, then, that in such cases the quality or richness of the mortar should depend upon the proportion of fine material in the mixture. For example, suppose that 1 cubic foot of gravel contains 0.1 cubic foot of sand, and that the voids in gravel with sand screened out measure 40 per cent. For general purposes this would suggest a one and two-fifths mixture; but since each cubic foot contains 0.1 cubic foot sand, 5 cubic feet of gravel will contain 0.5 cubic foot sand and the proportions should be changed to one part cement, one and one-half parts sand, five parts gravel.

Above illustration shows a wall laid up of 8x8x16-inch rock face and 4x8x16-inch plain face hollow cement building blocks. We recommend the use of alternate courses of 4 inches and 8 inches because it breaks the monotony frequently found in walls built of blocks of a uniform size.

Mixing Concrete

There is positively nothing more important in the making of cement building materials or which requires nearly so much attention and on which you can better afford to use time and care than the mixing of the concrete. We advise the use of a mixing machine where you have enough work to justify the purchase of this machine. A concrete mixer will pay for itself in a very short time, and insures a perfect mix. The real value of your building or work depends upon the life of the cement, and cement must be properly and well mixed with the sand and aggregates to obtain satisfactory results. In this catalogue we endeavor to explain the use of our different mixers, but if you do not use a mixer, you will find a mortar box,, say 4 feet wide and 6 or 8 feet long, with sides from 8 to 10 inches high, permits the best mixing of cement by hoe and shovel. Your mixing box or platform should be as near the machine as possible; the sand and gravel or crushed stone should be piled on either side of the mortar box to save as much time and labor as possible. Put the sand in the bottom of the box, then put in the crushed stone or gravel, and on top of this the cement. This should be mixed up dry with shovels or hoes until the entire mass shows a uniform color. Mix thoroughly. This is the time to have the cement evenly distributed into the sand and gravel before any water is applied. After thoroughly mixing the material, you can begin applying water, which should be turned on lightly or applied with a sprinkling can or spray nozzle from a hose and in comparatively small quantities. Do not get your mixture too wet. Work the dry material from the outside toward the center until all the water is taken up, then turn rapidly with a shovel and add additional water by sprinkling if it is necessary to do so. A mixture in which water can only be brought to the surface by vigorous tamping or by a sharp stroke from the flat side of the shovel has received the proper amount of water

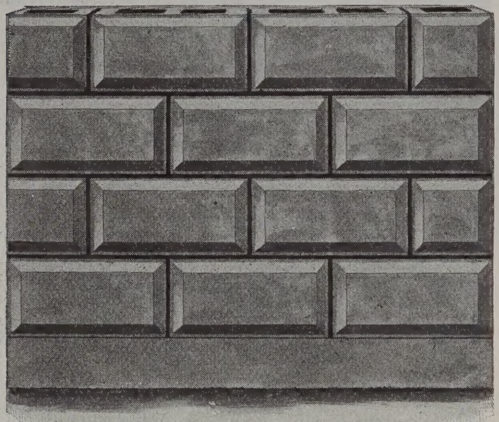


Above illustration shows a wall laid up of alternating courses of panel face and rock face blocks. The panel face block used is 8x8x16 inches and the rock face 4x8x16 inches.

You will find in a cement block or brick machine you will make a better block and can handle them more rapidly, as well as more satisfactorily if you will use your material as dry as you can to have it mould properly. If your material is too wet, it is likely to stick to the face plates or other parts of the machine. Do not mix up too much material in one batch. It should be mixed in small quantities so that it can be used up inside of half or three-quarters of an hour from the time water was applied. It should not be allowed to stand more than one hour.

Coloring Cement Blocks and Brick

Coloring matter is sometimes used in facing cement brick and hollow blocks for decorative purposes. Mineral colors are the safest to use. To make colored stone take the proportion of coloring and cement as outlined below, and mix them thoroughly while dry, then add the sand, etc. Mix all together until of uniform color, then add water and continue to mix thoroughly until it is uniform throughout. Our block machines being "face down," they only require a colored facing material to produce the desired effect.



The illustration shows a wall laid up of 8x8x16-inch panel face hollow cement blocks. This style of facing is desirable for foundations in many cases and is often used for belt courses over windows, or between the stories of a building. It is also frequently used for building up corners. The corners of a wall might be laid with panel, tool or corrugated face and the rest of the walls of rock face or broken ashler.

For White Stone—White Portland cement, one part; pulverized lime, one-fourth part; pulverized marble, one-half part; light colored sand, one part. On account of the inferiority of white Portland cement, the above is seldom used. **Red Stone**—One sack cement, 200 pounds sand, 5 pounds violet oxide iron (raw). **Bright Red Stone**—One sack cement, 200 pounds sand, 7 pounds English red. **Brown Stone**—One sack cement, 200 pounds sand, 4 pounds brown ochre. **Dark Blue Stone**—One sack cement, 200 pounds sand, 4 pounds ultramarine blue. **Gray Stone**—One sack cement, 200 pounds sand, 1 pound excelsior carbon black. **Black Stone**—One sack cement, 200 pounds sand, 3 pounds excelsior carbon black. The ultramarine blue is found to add to the quality of mortar if not used excessively. Most other coloring matter should be used sparingly.

Waterproof Cement Blocks and Brick

Concrete blocks can be made partially waterproof by the use of hydrated lime mixed with the facing or throughout the block as follows: To each bag of cement, weighing 95 pounds, add 15 to 20 pounds of ground hydrated lime free from grit; mix the cement and lime dry to a uniform color and then mix with the sand, gravel and crushed stone; the aggregates should be so graded as to produce the least voids in the mass.

Another formula recommended by many users of cement is a very simple and inexpensive one, viz.: Dissolve ½ pound shaved Castile soap in 1 gallon of water; also dissolve ½ pound of powdered alum in 4 gallons of water; when the surface is dry, apply the soap wash at boiling heat, with brush; do not froth the soap. After the soap wash is thoroughly dry, apply the alum wash in the same way, only at a temperature of about 70 degrees. The applications should be made twice when it is wished to secure perfect impenetrability to water. This securely closes all the pores on the surface, and its use on government buildings has shown its permanence by many years of satisfactory use

OUR CUSTOMERS THINK OUR CEMENT BLOCK MACHINES THE BEST TO BE HAD.

Sears, Roebuck & Co., Chicago, Ill.
Tupelo, Miss., Dec. 1, 1906.

Dear Sirs:—Yours of recent date to hand, in which you state you had shipped the clamp lever No. 7, which was broken in shipment. The broken clamp did not interfere with operating the machine, so we went to work with the machine the day after receiving it and have had blocks made daily since. Can say we are making as perfect a block as can be desired. An eight year old boy makes the blocks, and the man who mixes carries them from the machine.

As formerly stated, it is the best machine we have examined or tried, the blocks being of proper size and bond well. We permitted a man yesterday who has a sand pallet machine to make 125 blocks on our machine, as it worked so much better and faster. For our use would not ask for a better machine. If we can procure as good a mixer as we have block machine, will be satisfied. Very respectfully, W. F. RILEY.

Sears, Roebuck & Co., Chicago, Ill.
Fairmount, Ill., Nov. 31, 1906.

Gentlemen:—We have one of your X-L-ALL Cement Block Machines, size 8x8x16 inches, and the machine is all right and makes a perfect block. We have used the machine for some time and find it very satisfactory. You can refer any one to me or use my name anywhere you want to in regard to the X-L-ALL Cement Block Machine. Yours respectfully, THOS. HOLLOWELL.

Sears, Roebuck & Co., Chicago, Ill.
Weatherly, Pa., Dec. 7, 1906.

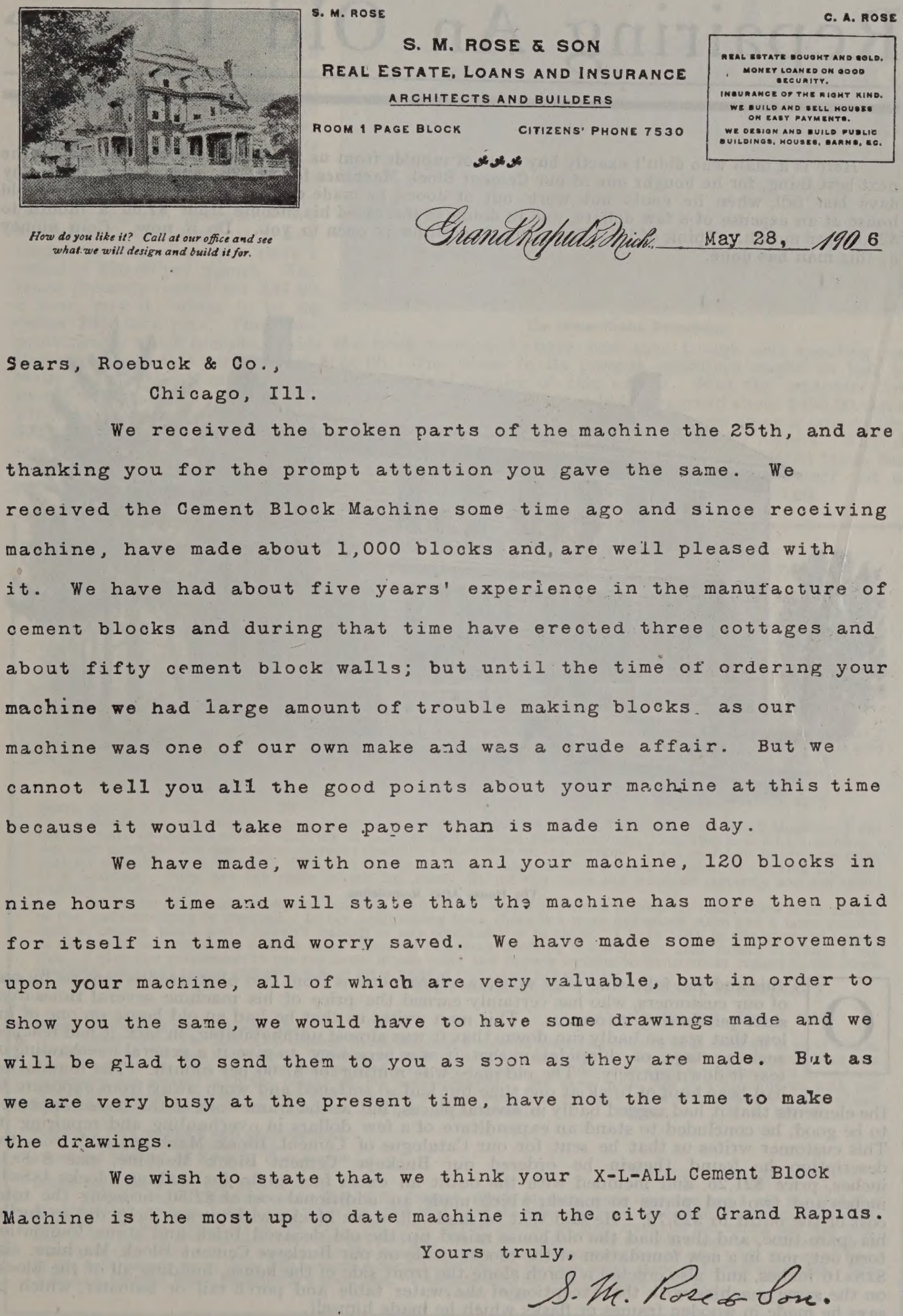
Gentlemen:—Your letter concerning working of X-L-ALL Cement Block Machines received. In reply, will state that the blocks made with the machine are all O. K. I hope to give the machine a complete test next spring for speed, etc., and will let you know the result of such test.

Yours truly, GUSTAV HEYDEN.

Sears, Roebuck & Co., Chicago, Ill.
34 Valley St., Dayton, Ohio, Dec. 1, 1906.

Dear Sirs:—In reply to your letter of recent date, wish to say that the X-L-ALL Cement Block Machine I purchased from you proved very satisfactory. We have a very beautiful two-story double house as the result. As to dampness, I can say that we have had a very damp season so far, but the house does not get one bit damp.

We got out not less than one hundred blocks a day on the X-L-ALL Cement Block Machine. Did very well, I think. We are more than pleased with it. Yours truly, J. E. YOUNG.



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ARCHITECTS AND BUILDERS
ROOM 1 PAGE BLOCK CITIZENS' PHONE 7530

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MONEY LOANED ON GOOD SECURITY.
INSURANCE OF THE RIGHT KIND.
WE BUILD AND SELL HOUSES ON EASY PAYMENTS.
WE DESIGN AND BUILD PUBLIC BUILDINGS, HOUSES, BARNS, &C.

How do you like it? Call at our office and see what we will design and build it for.

⁂

Grand Rapids, Mich. May 28, 1906

Sears, Roebuck & Co.,
Chicago, Ill.

We received the broken parts of the machine the 25th, and are thanking you for the prompt attention you gave the same. We received the Cement Block Machine some time ago and since receiving machine, have made about 1,000 blocks and, are well pleased with it. We have had about five years' experience in the manufacture of cement blocks and during that time have erected three cottages and about fifty cement block walls; but until the time of ordering your machine we had large amount of trouble making blocks. as our machine was one of our own make and was a crude affair. But we cannot tell you all the good points about your machine at this time because it would take more paper than is made in one day.

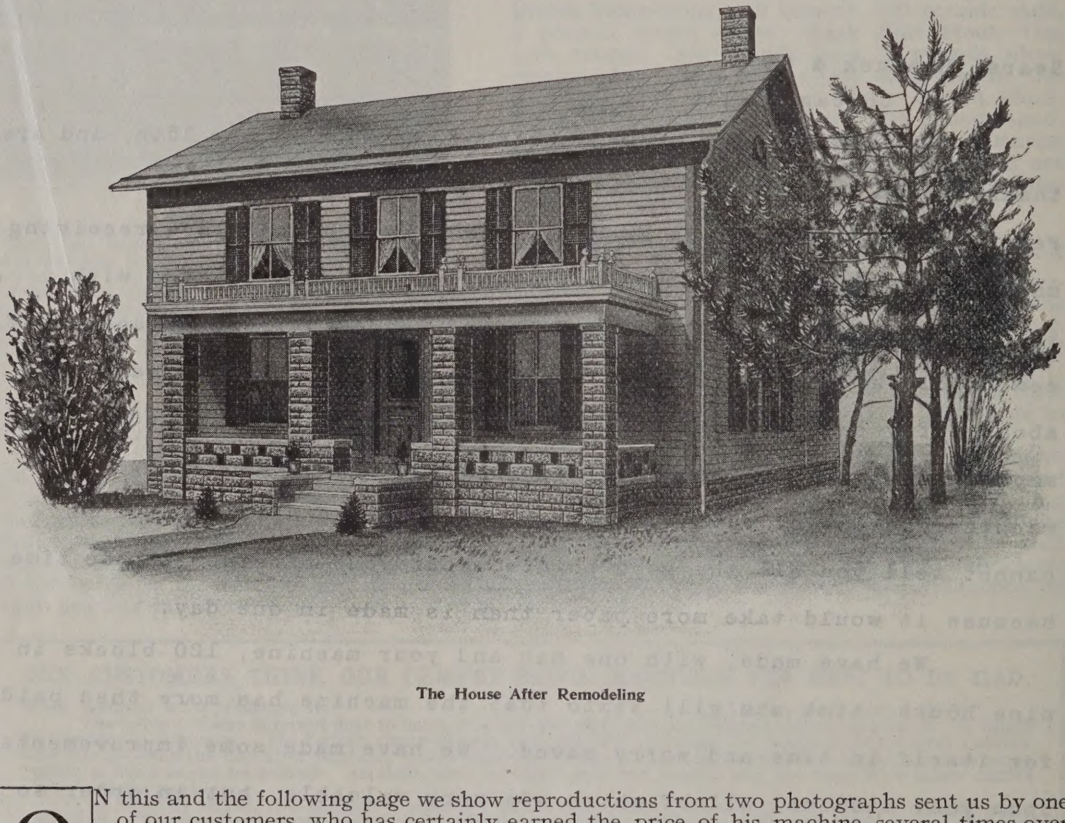
We have made, with one man anl your machine, 120 blocks in nine hours time and will state that the machine has more then paid for itself in time and worry saved. We have made some improvements upon your machine, all of which are very valuable, but in order to show you the same, we would have to have some drawings made and we will be glad to send them to you as soon as they are made. But as we are very busy at the present time, have not the time to make the drawings.

We wish to state that we think your X-L-ALL Cement Block Machine is the most up to date machine in the city of Grand Rapids.

Yours truly,
S. M. Rose & Son.

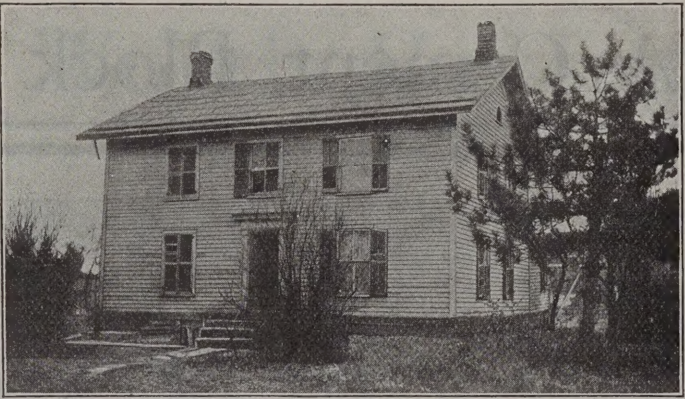
Repairing An Old House

Here is a man who didn't exactly buy a set of moulds from us for coining money, but he did the next best thing, for he bought one of our Cement Block Machines for $21.25, and during the rainy days last fall, when he could not work out of doors, he made cement blocks and repaired an old house at an expense of a few dollars, and in doing so increased his income from $7.00 a month to $20.00 per month. Think of it! The same proposition is open to you. Do it now. Coin money as this man has done.



The House After Remodeling

ON this and the following page we show reproductions from two photographs sent us by one of our customers, who has certainly earned the price of his machine several times over since purchasing it from us. This man writes us that he had an old house on one of his lots that was so badly run down that it was almost uninhabitable; in fact, it had reached such a stage of dilapidation that it was necessary to give it a general overhauling or tear it down entirely. The old place was renting for $7.00 per month. The foundation had been built of brick at one time but had so softened and worn away from exposure to the elements that it had sagged badly in several places, but as the framework of the house appeared to be good, he concluded to stand an expenditure of a few dollars in overhauling and repairing it. This customer writes us that he sent for our Catalogue of Cement Block Machines and from the description he found therein he ordered our Buckeye Cement Block Machine, size 8x8x16 inches, price $21.25, and included with the outfit an extra face plate for making blocks 4x8x16 inches and two end plates to match, which made an additional cost of $2.50, bringing the total cost of the outfit to $23.75. He said that he made all of his blocks without any help, did so during his spare time, and then had the old house raised up, the old decayed brick and stone foundation torn out, put in a new foundation of the blocks made on our Buckeye Cement Block Machine, size 8x8x16 inches, and also erected a porch along the front side of the house, building all of the blocks on the same machine with the exception of the water table and porch rail or baluster, which he says he made in wooden frames or flasks which he made himself.


The House Before Remodeling

In addition to the new foundation and porch, there were new chimneys built on the house to take the place of the old dilapidated brick chimneys, which had worn away and were worse than valueless. This customer paid $1.90 per barrel for cement and writes us that he used 325 blocks 8x8x16 inches and 300 blocks 4x8x16 inches. These figures include the chimneys, porch and foundation complete as shown in large photograph herewith. We are advised that there is a new tenant in this place who pays a rental of $20.00 per month. The house formerly rented for $84.00 a year; now it brings in to its owner $240.00 a year. These improvements, which include, beside the work mentioned above, new eave trough and spouting and repainting, cost this party about $160.00. The house in its present condition ought to last for many years without any further expense toward repairs of this nature. Had the customer continued renting his house at $7.00 per month for five years, he would have earned about $400.00. out of which taxes, insurance and other expense must have been paid, while the same house is now earning $240.00 a year, or $1,200.00 for the term of five years at an expense of $160.00 for repairs. What do you think of this proposition as a money maker? Haven't you got some old dilapidated house that will earn you the same proportion of increase as has been the case with this customer? At an expenditure of less than $200.00 our customer has increased his earnings exactly $780.00.

A PLEASED CUSTOMER IS OUR BEST ADVERTISEMENT.

Mitchell, Neb., Dec. 7, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Your letter of recent date received, and in reply will say I bought one of your X-L-ALL Cement Block Machines and find it all and more than you claim for it. It was easy and simple to manipulate. I made on an average 100 blocks per day, hauling our own sand with the help of a sixteen year old boy. I put up a house 24x24 feet, 9 feet high, grouted up a cellar 10x14 feet to the floor, laid a foundation 18 inches high, including work of laying up stone, lime and sand, for $128.00. This was cheaper than lumber by $30.00, and is more substantial. I lathed and plastered it to keep out frost and dampness, but believe if the stone is well seasoned, this would not be necessary. Yours respectfully, J. E. KEEBAUGH.

McCordsville, Ind., Dec. 9, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In regard to the X-L-ALL Cement Block Machine purchased some time ago, will say that I consider it as good as most of the $100.00 to $200.00 machines. Just as good blocks can be made with it and as easily and quickly as with machines costing three or four times as much. I am well satisfied with it.

Yours truly, FLOYD HELMS.

Witt, Ill., Dec. 15, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your letter of recent date, regarding the X-L-ALL Cement Block Machine, I will hereby state to anyone who is thinking of purchasing a cement block machine, that the X-L-ALL machine is the most practical and the easiest operated machine I have seen on the market. I am confident in my own mind that its capacity can't be beat. The size blocks made on this machine is most practical in erecting any kind of a building. They are the right length for joists, fit up the doors and windows correctly and are easily handled by one man.

As to the nature of the cement building block, I will say, if the block is properly made there is no danger of the walls sweating or freezing. In my neighboring town there is a large dry goods store and a large grocery built of cement block and I haven't learned of any complaint as to them. I have faith in the practical nature of the block, and intend to build a large ten-room two-story dwelling house in the near future in which I will live. I give you permission to use my name if you wish, and anyone wishing to write me in regard to the block machine, they will please enclose a stamp for a prompt reply and full details.

Yours respectfully, HENRY L. KENNETT.

Dublin, Ind., Dec. 2, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—The X-L-ALL Cement Block Machine I ordered from you came to us at once, all in good shape, except two of the cast iron pallets, which were broken in transit, and which were replaced at once without one cent of cost to us. We are more than pleased with the machine. It does more than you claimed for it, and our customers are pleased with the blocks we are manufacturing. We have made 200 rock face blocks with the X-L-ALL Machine in eight hours and only two of us at work, and we have never seen or heard of any of our blocks holding dampness. We consider it the best machine made. Yours, H. L. BOYD.

CHESTER HILL GARDEN AND GREENHOUSE.
ALBERT NEIFER & SONS.
Plants and Seeds of All Kinds in Their Season.

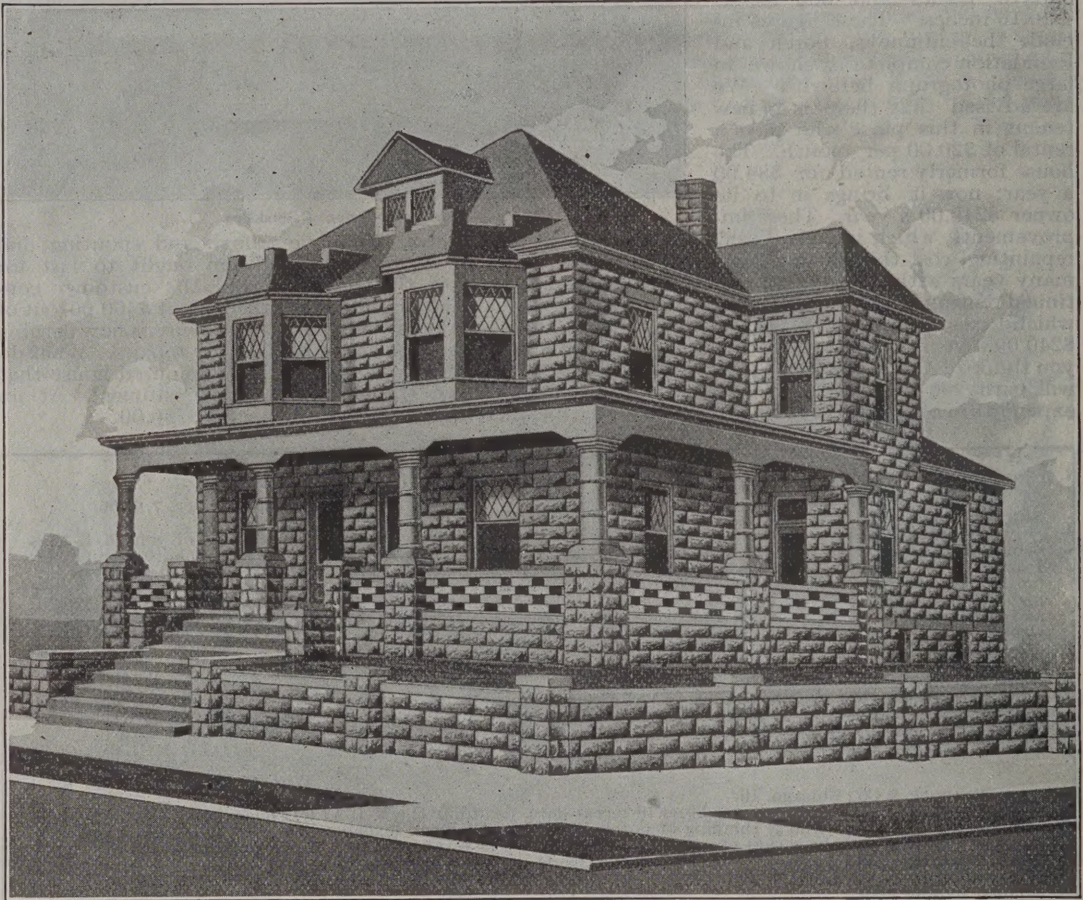
Weston, O., Nov. 28, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I received your X-L-ALL Cement Block Machine some time ago and I will say that the machine can't be beat, I don't care what the price may be of the other machine. Your machine makes a fine block and just the right size to lay in the wall. Mr. Peter Snyder got one of your machines last spring and has built four or five houses, and they are first class and perfectly dry on the inside. Why shouldn't they be? Cement blocks when properly made will not take water like brick. I have compared cement houses and brick houses of late. In the next twenty years there will be more cement buildings put up than wood, stone and brick combined. The X-L-ALL Cement Block Machine is a good one. I enclose an order for 150 more pallets.

Yours truly, ALBERT NEIFER.

A Cement Block Residence

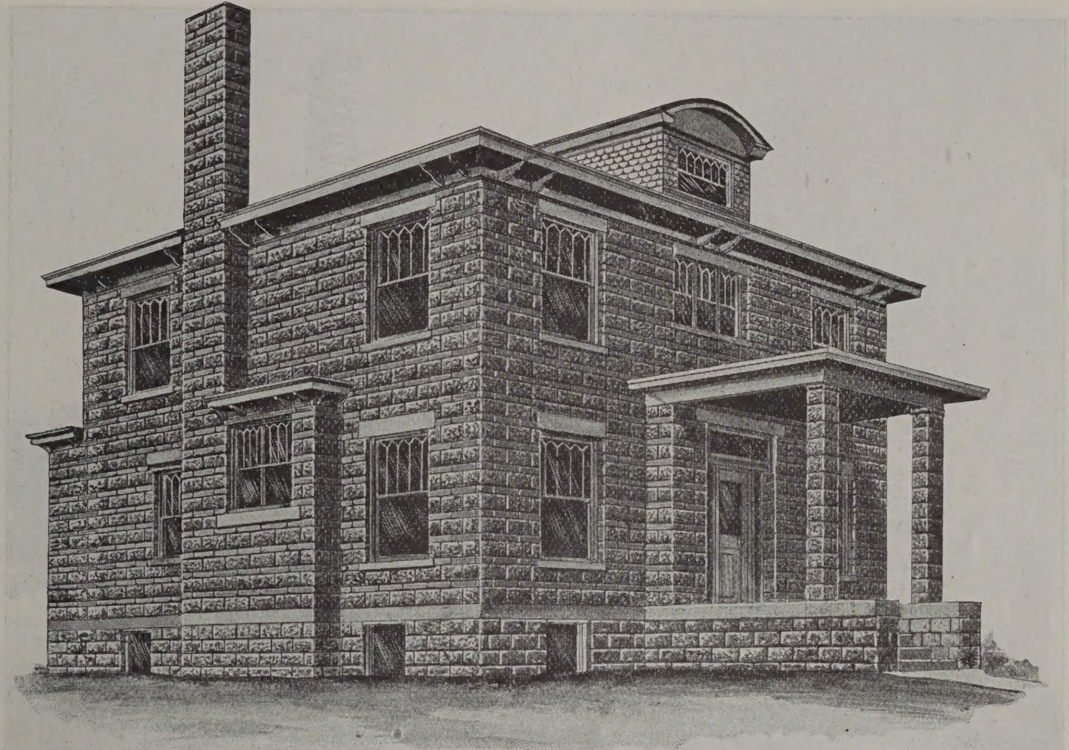


The Great Adaptability of Cement Blocks Is Well Shown in This Picture

THE commodious and attractive home illustrated herewith shows the possibility of cement block construction. The blocks in the retaining wall, the blocks in the house, the blocks for the porch can all be made with the machines that are illustrated in this catalogue. The retaining wall and coping, the porch rail, the caps and sills for windows and doors and the steps can be made in moulds built into place on the wall or may be made with our cap and sill machine. It requires careful attention to every detail in making good blocks, but no special knowledge or expert workman is required to make them. The cement block house does not require frequent painting; in fact, it will cost no more for the cement to make the blocks for this house than it would cost to keep it well painted for twenty or twenty-five years. In many sections of the country contractors will build this style house from cement blocks for a lower price than they charge for a high quality frame house. The cost will be very much less than the cost of natural cut stone and in no part of the United States could a brick house be built so cheaply. The blocks shown in the illustration may be made on either the X-L-ALL or Buckeye Cement Block Machines.

Sears, Roebuck & Co., Chicago, Ill.
Dear Sirs:—I have one of your Buckeye Cement Block Machines and it makes good blocks.
Yours truly, F. E. RICHARDSON.

A Home Worth Having



THE illustration shows a splendid two-story up to date residence erected entirely of hollow cement building blocks. The design of the walls of this house is especially pleasing, in view of the fact that the customer has used 8-inch and 4-inch face blocks alternately. Note that the first course from the water table is of 8x8x16-inch blocks of rock face design, while the second course is from 4x8x16-inch blocks of tool face design. This breaks the monotony of the wall, makes its appearance much more like regular cut stone and adds practically nothing to the cost of the material and only a few extra dollars in labor of making the blocks and laying up the wall. This house has a large fireplace projecting from the wall, built of cement blocks, and a chimney built up on one side of the house of the same style blocks as were used in the walls of the house. The front porch posts or columns were built of blocks made on our 10x10-inch porch column moulds as shown on page 99. The entire porch is of cement block construction.

ANOTHER PLEASED OWNER OF A BUCKEYE CEMENT BLOCK MACHINE.

49 Rayner St., Cleveland, Ohio, Dec. 10, 1906.

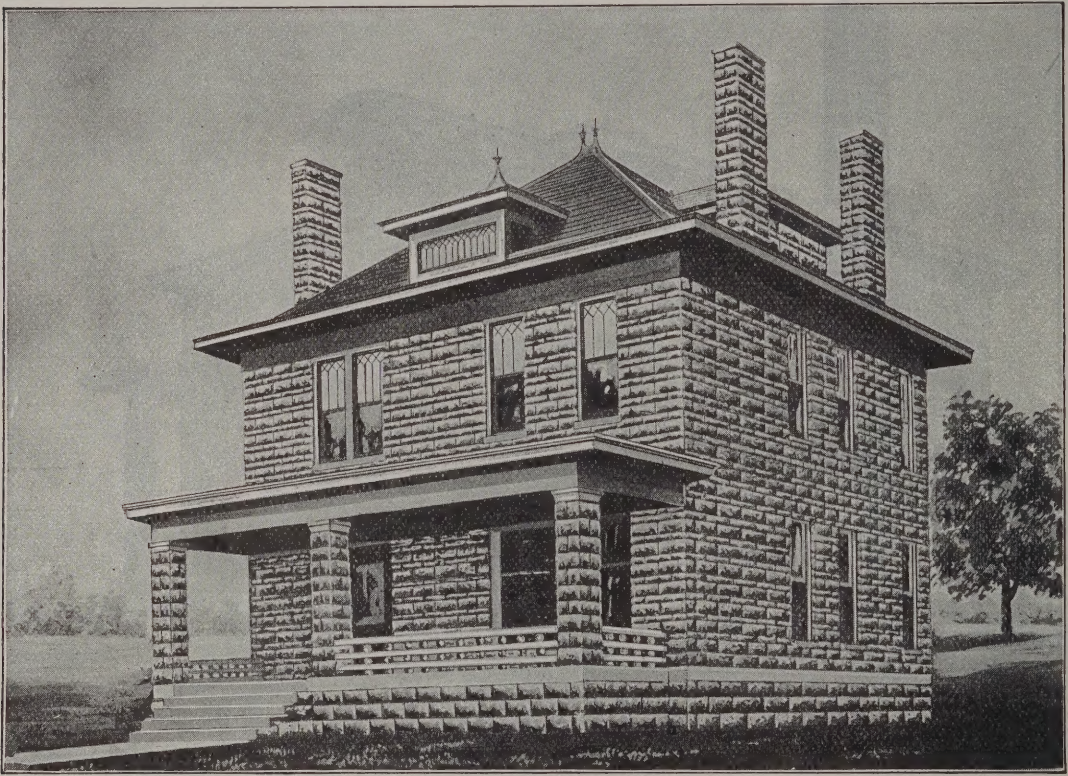
Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—I have received the Buckeye Cement Block Machine ordered from you; also the repairs for same and find them very satisfactory, with many thanks.

The Ashler Face Attachment ordered from you makes the prettiest block in the city. I have quite a number of orders for this style of block and, as I desire to start in the cement block business, it will be necessary to order more machines and machinery.

Up to the present time I have not received your special catalogue and would thank you to mail same to me as soon as possible. Let me know if you make forms or attachments for making square blocks, say about 10-inch and 14-inch squares, for porch posts. Yours truly, FRANK L. REES.

An Artistic Concrete House



A FINE residence, erected entirely of 8x8x16 and 4x8x16-inch hollow concrete blocks, made on our X-L-ALL Cement Block Machine. The foundation under this residence was made of 8x10x20-inch blocks on our large size X-L-ALL Cement Block Machine and the walls are made of 4 and 8-inch blocks all 16 inches long. The porch rail is made entirely of concrete. The chimneys on this house are made of alternating courses of 4 and 8-inch chimney blocks and carry out the same general appearance of the walls of the house.

ONE OF THE MOST SATISFACTORY MACHINES ON THE MARKET.

Seneca, Neb.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Replying to your letter of recent date, will say I purchased the Interlocking Cement Block Machine from you last August and have used it to some extent and am convinced that it is one of the most satisfactory machines on the market, from the fact that it makes an "L" block, which can be built into a double wall with air space between and no solid part between the blocks to cause moisture. It certainly makes a block for a perfect wall.

Yours truly,

J. M. WILSON.

SAYS HIS ONLY MISTAKE WAS IN NOT BUYING SOONER.

Petersburg, Ind., June 24, 1906.

Sears, Roebuck & Co., Chicago, Ill.

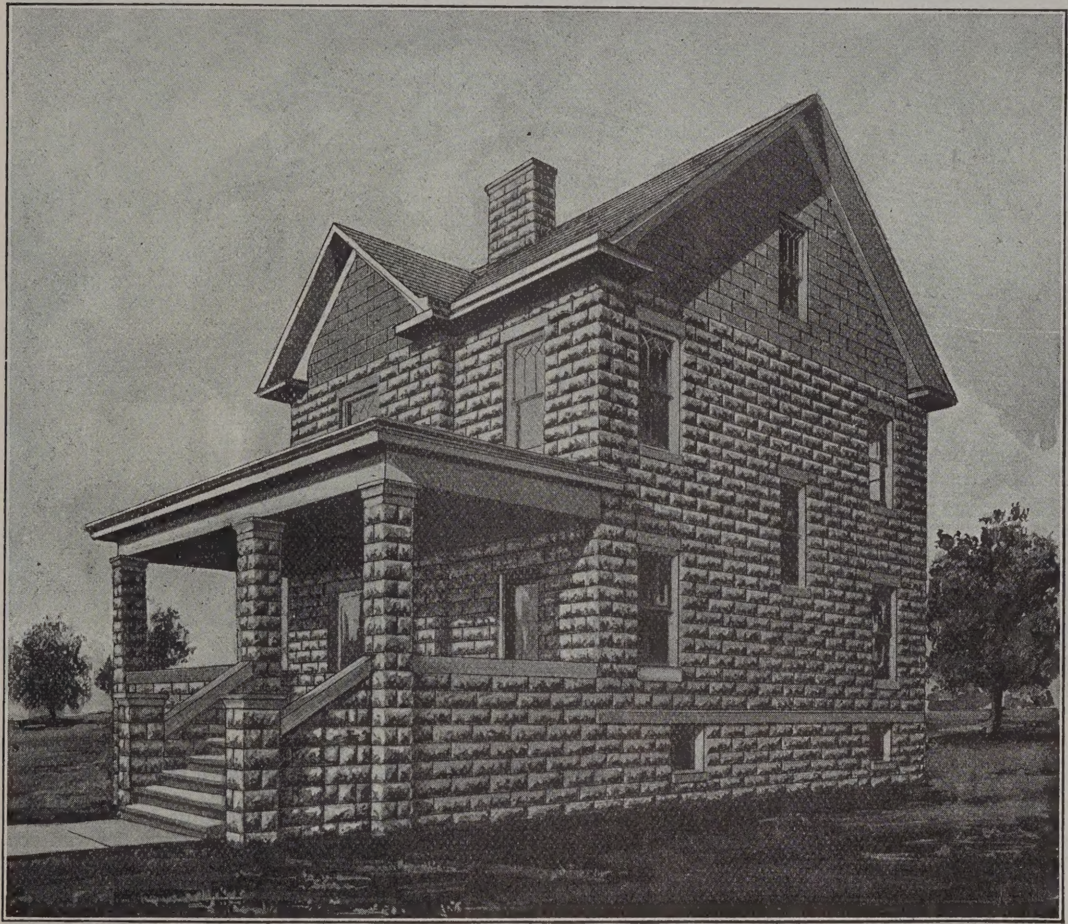
Gentlemen:—Your letter received and will say in reply that I received one of your Buckeye Hollow Block Machines this spring. It is O. K. It has proven entirely as represented. My only mistake was by not buying sooner. My son-in-law has but one arm and can operate and make as good blocks as any man so you know by this that the Buckeye Cement Block Machine is O. K

Wishing you success and recommending the Buckeye Hollow Cement Block Machine to all, I remain

Yours respectfully,

J. E. NICELY

A Modern House of Low Cost



THE above illustration shows a thoroughly modern and up to date house, built in one of the suburbs of Chicago. This house is constructed entirely of 8x8x16-inch blocks. The foundation and main walls of the house are made of 8-inch blocks with rock face, while the gable ends of the walls are made of plain face blocks. The porch is constructed of the same size blocks as were used in the construction of the house. This house is about 30x24 feet, contains six good large sized rooms and contains about 3,170 blocks.

ONE MAN WITH AN X-L-ALL MAKES MORE BLOCKS THAN TWO MEN WITH ANOTHER MAKE OF MACHINE.

JOHN RISELING,
Dealing in Real Estate,
1226 Baker Street.

Galena, Kans., Nov. 30, 1906.

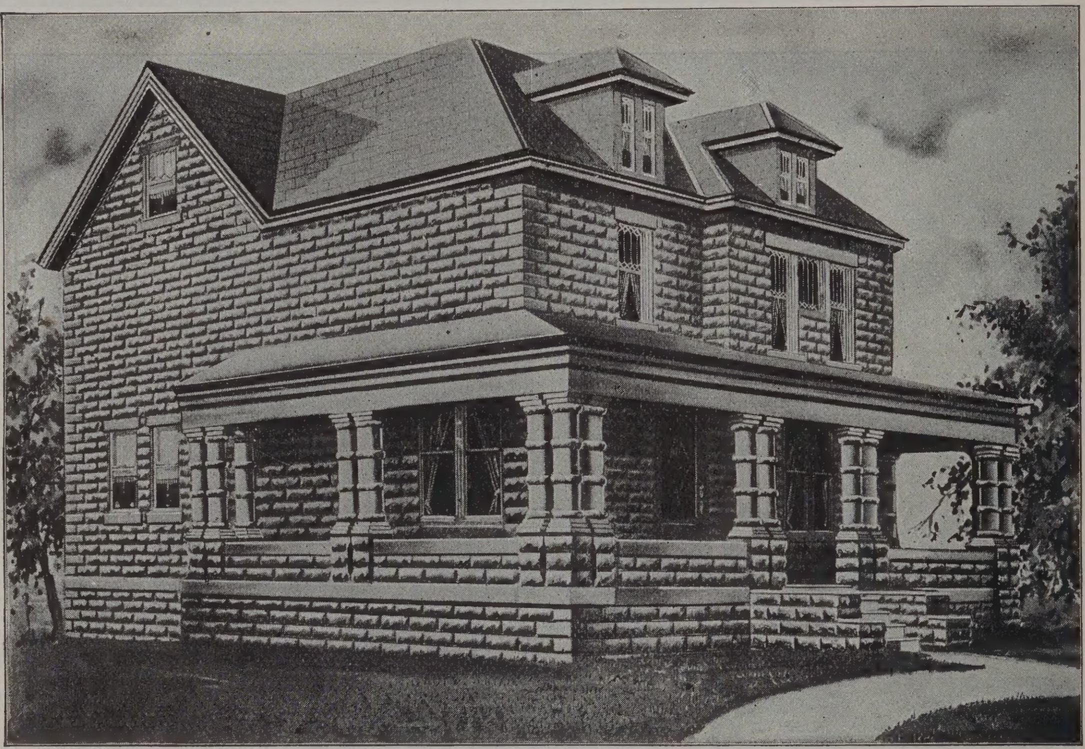
Sears Roebuck & Co., Chicago, Ill.

Kind Friends:—The X-L-ALL Cement Block Machine I bought of you is a fine machine. It does splendid work; makes as good blocks as any machine I have ever seen. I have made 100 blocks in one day alone while other machines I have seen it took two men to make seventy-five. In building houses with cement blocks, the face of the block wants to be made with more cement than the inside of the block and if properly made, no dampness can penetrate for they will be just as solid as a natural rock. Respectfully yours,

JOHN RISELING.

COLUMBIA UNIVERSITY

A Substantial Cement Residence



THIS beautiful residence is entirely of cement. The foundation, walls, chimneys and all of the porch work is cement. The porch piers are made on our Buckeye mould, as shown on page 101 of this catalogue. These porch columns are made in sections, and we furnish moulds for making either round smooth columns or fluted columns, and division caps or band moulds can be had for making either smooth face or rock face, as wanted. This customer has used the smooth round sections and rough face division bands, thereby producing a very nice effect. Corner columns are built in three sections, making it very heavy and massive in appearance. All of the partitions in this residence are made of hollow cement blocks from the basement to the top. Partition walls built of hollow cement blocks are fireproof and worth many times their value in large buildings of this kind.

This is a most complete and up to date residence, and every block, every cap and sill, all of the porch work can be made on our line of concrete machinery

Geneva, Ind., Dec. 5, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your letter of recent date, will say the X-L-ALL Cement Block Machine I purchased from you makes a good quality of blocks and I would not ask for better. I have erected a building for my own use from blocks made on your machine. I find the inside walls perfectly dry. There is no dampness whatever.

Yours very truly, A. F. CARPENTER.

J. P. BARTLETT, Contractor and Builder.

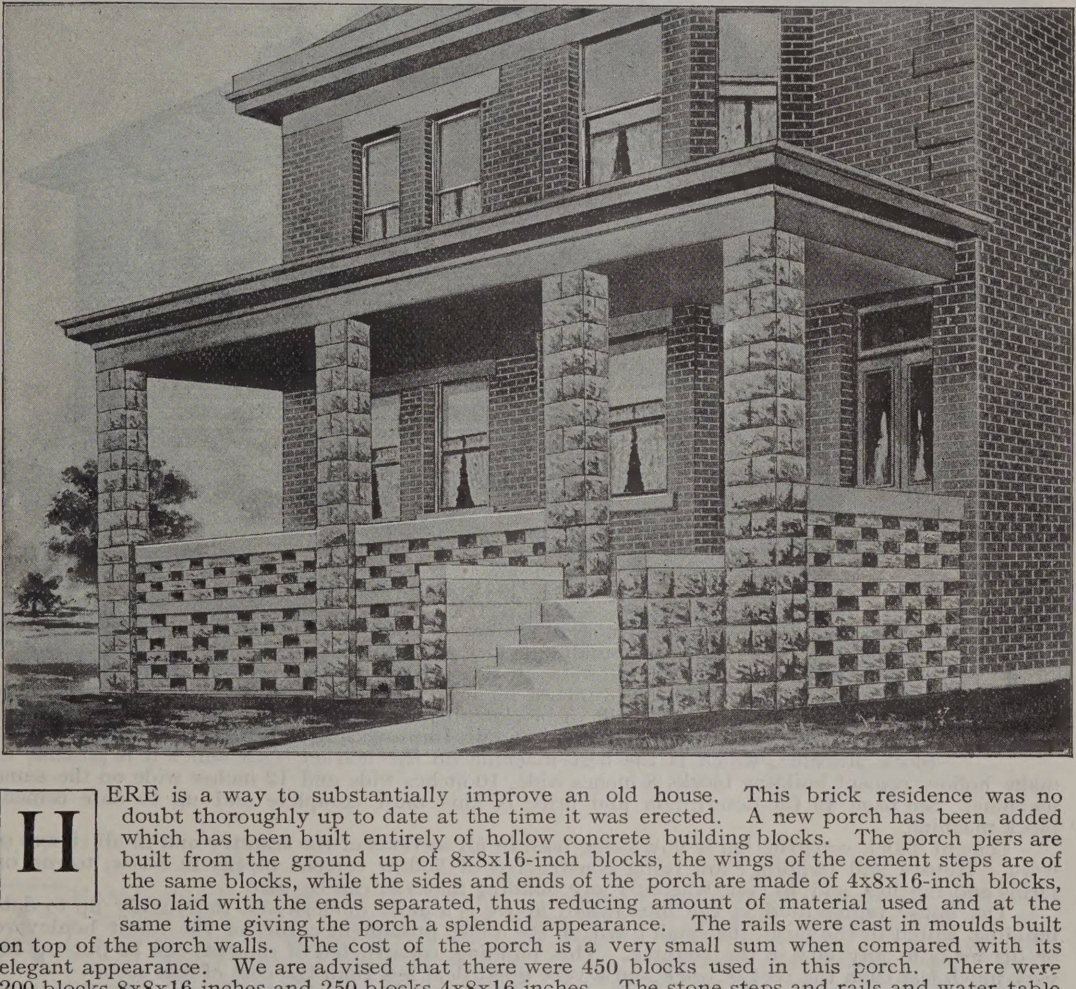
Pittsboro, Miss., Dec. 4, 1906.

Sears Roebuck & Co., Chicago, Ill.

Gentlemen:—I am well pleased with the X-L-ALL Cement Block Machine I purchased from you. I do not see how I could do without one. It is the very thing for contractors and builders. The block is so much nicer and makes a building show up better than brick, even in foundations for frame buildings. I have compared the blocks from my machine with blocks made on two other machines, and everybody who saw them says there is no comparison, as mine makes a smooth, neat block. All the other machines cost twice the price I paid for mine. I will always have a block machine for my work and patronize Sears, Roebuck & Co.

Yours truly, J. P. BARTLETT.

Improving An Old House



HERE is a way to substantially improve an old house. This brick residence was no doubt thoroughly up to date at the time it was erected. A new porch has been added which has been built entirely of hollow concrete building blocks. The porch piers are built from the ground up of 8x8x16-inch blocks, the wings of the cement steps are of the same blocks, while the sides and ends of the porch are made of 4x8x16-inch blocks, also laid with the ends separated, thus reducing amount of material used and at the same time giving the porch a splendid appearance. The rails were cast in moulds built on top of the porch walls. The cost of the porch is a very small sum when compared with its elegant appearance. We are advised that there were 450 blocks used in this porch. There were 200 blocks 8x8x16 inches and 250 blocks 4x8x16 inches. The stone steps and rails and water table are of concrete and made on the Ohio Cap and Sill Machine. The concrete on the entire job cost less than $50.00.

Rockbridge, Ohio, Nov. 30, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to your inquiry about the block machines ordered from you, will say that I am very well pleased with them. I purchased two machines from you, one X-L-ALL and one Buckeye machine. I like both of them very well.

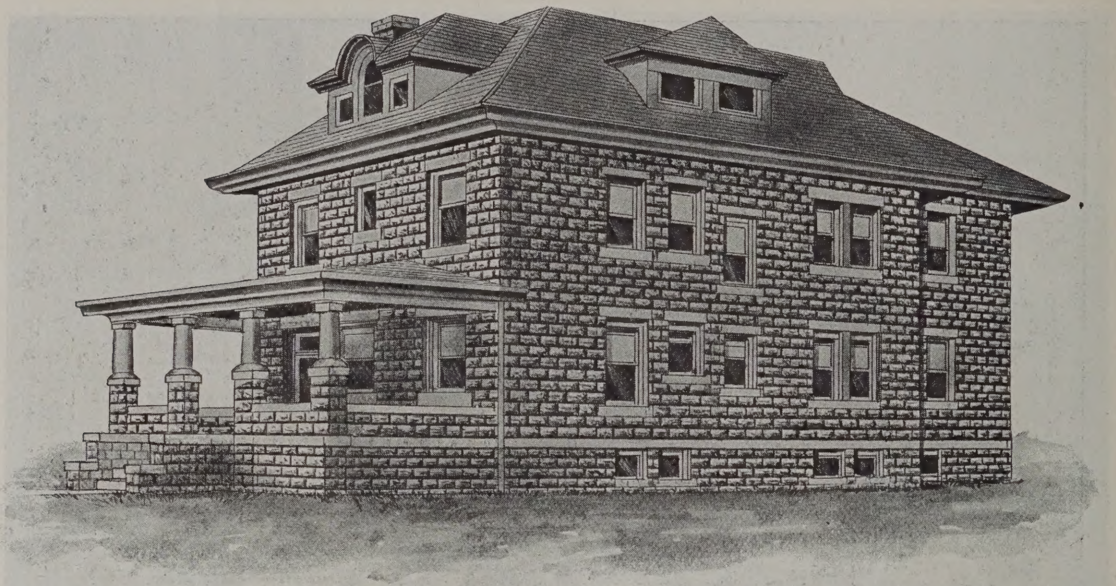
I did not make so many blocks this season because it was rather late before I got ready for the business, but made enough to thoroughly test the machines. There are several different makes of machines near here, but I have not seen any that I think will make any better blocks or make them with more rapidity than mine. Making blocks rapidly depends upon the amount of tamping and the rapidity with which the operator works. Making good blocks depends greatly on the amount of tamping; the more they are tamped, the better the blocks.

With a face down machine like the X-L-ALL and the Buckeye, I believe that damp walls can be entirely obviated. If the block is made of a concrete of the proper proportions, say one-third cement to two-thirds good sharp sand, and thoroughly tamped and well seasoned, it will be entirely impervious to water. I see no reason why it would not. Water tanks and cellar walls are made of that material and prove impervious to water and perfectly satisfactory; why not blocks? The X-L-ALL machine is a good, strong, easily operated, handy and simple machine, and makes a fine block for building purposes. The Buckeye machine makes just as good a block with a single core. It is not, perhaps, as strongly built a machine as the X-L-ALL, but it is handy, simple and rapid

Respectfully,

JOHN T. KELLY.

A Large Concrete Residence



THE illustration shows a large modern residence constructed entirely of hollow concrete building blocks. This entire building is made of 16-inch blocks. Foundation is built of blocks 8 inches high, 12 inches wide (in the wall) and 16 inches long. The walls of the first story are built of blocks 8 inches high, 10 inches wide (in the wall) and 16 inches long. The second story is built of blocks 8 inches high, 8 inches wide (in the wall) and 16 inches long. See the description of our Improved X-L-ALL Combination Cement Block Machine, which is the best machine on the market with which it is possible to make hollow cement building blocks 8 inches wide, 10 inches wide and 12 inches wide on the same machine. See page 45 for description and price of this most complete and up to date cement block machine.

Cement block construction is now being used in all sections of the country and in all classes of work. Houses and buildings are being constructed of hollow cement blocks in cities, towns, on farms and ranches, and, in fact, wherever any building material can be used.

The house represented in the illustration above is a most modern and thoroughly up to date building, suited to the farm, the small town or the most prominent corner of the finest boulevard or driveway in any city in the country. This building, constructed of cement, can be put up for very much less than the cost of brick and a very great deal less than the cost of real stone.

Concrete block construction is practically everlasting. The blocks do not scale off, discolor or disintegrate by the action of the elements, as is the case with the very best of real building stone. The window sills and window caps, door sills and caps, the water table, both around the building and the porch, the cement steps leading up to the porch and the porch rail on top of the baluster rail, can all be made on the Ohio Cap and Sill Machine, as fully illustrated and described on pages 93 and 94 of this catalogue.

The blocks used in the construction of this building, in all three widths, namely 8-inch, 10-inch and 12-inch, all of which have an 8-inch face and are 16 inches long, can be manufactured on either the Improved X-L-ALL Combination Machine or the Improved Buckeye Machines, as shown in this catalogue.

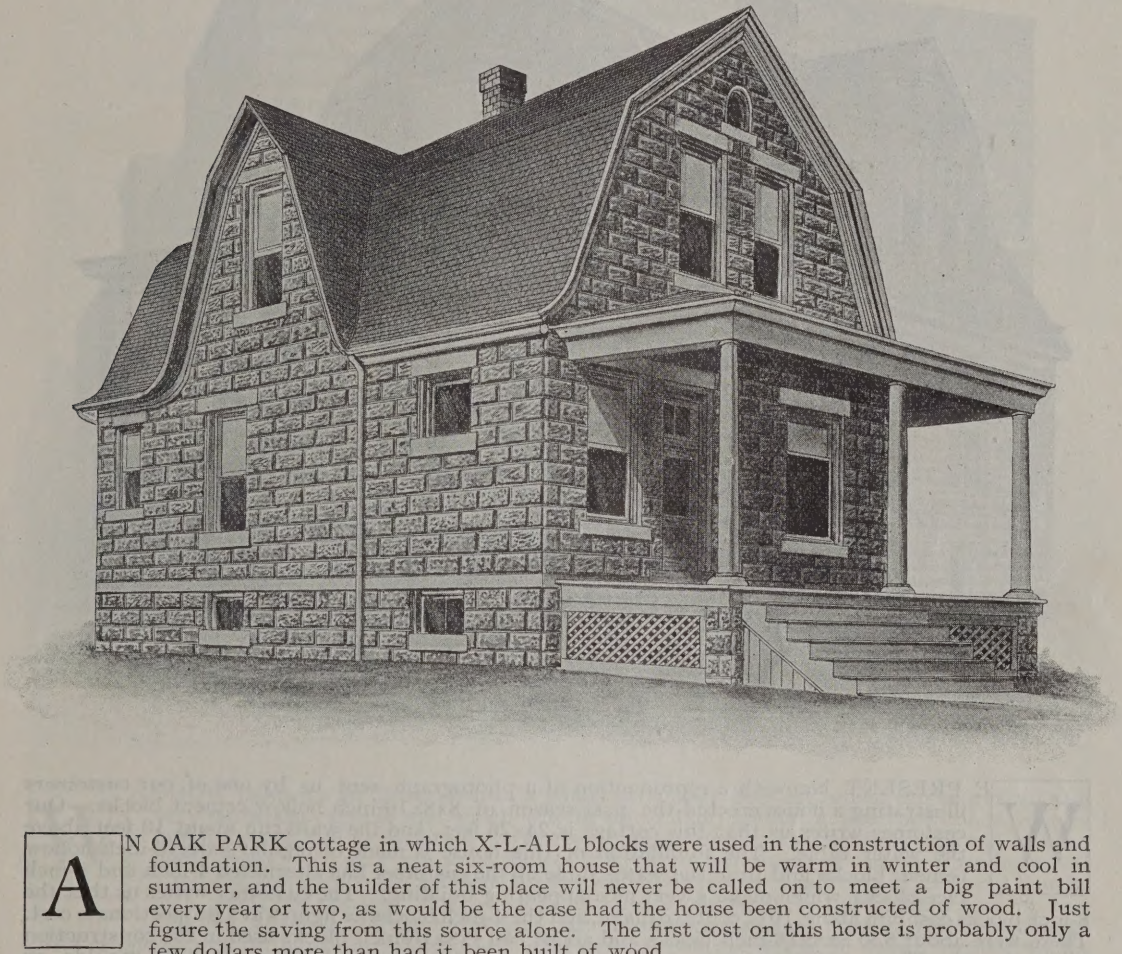
Carthage, N. Y., Dec. 7, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—Having just received an X-L-ALL Cement Block Machine from you, I thought I would write and tell you that I am more than pleased with it. The castings are heavier and changes can be made quicker on it than on any machine I have ever seen. I have had three years' experience in making cement blocks and have used machines costing from $300.00 to $500.00, and I am fully convinced that your X-L-ALL Cement Block Machine will make just as good and as many blocks per day as any machine I have ever used.

Yours truly, GEO. W YOUNGS.

A Cement Block Cottage



AN OAK PARK cottage in which X-L-ALL blocks were used in the construction of walls and foundation. This is a neat six-room house that will be warm in winter and cool in summer, and the builder of this place will never be called on to meet a big paint bill every year or two, as would be the case had the house been constructed of wood. Just figure the saving from this source alone. The first cost on this house is probably only a few dollars more than had it been built of wood.

WARDEN'S OFFICE, WEST VIRGINIA PENITENTIARY.
C. E. HADDOX, Warden

Moundsville, W. Va., Dec. 10, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—Some time since I purchased for the West Virginia Penitentiary one X-L-ALL Cement Block Machine to manufacture blocks to be used in a barn for the institution. We have at this date manufactured over six thousand (6,000) blocks, and are now erecting the barn in question. The blocks are of all kinds, including foundation and superstructure, and are as good blocks as could be made on a machine costing ten times the money The blocks used above the grade line are rock faced and the surface is made from one (1) part Lehigh cement and two (2) parts Lake Erie sand, and make a block as white as Bedford limestone. As soon as the barn is completed, other blocks will be moulded for additional structures.

Yours truly,
C. E. HADDOX.

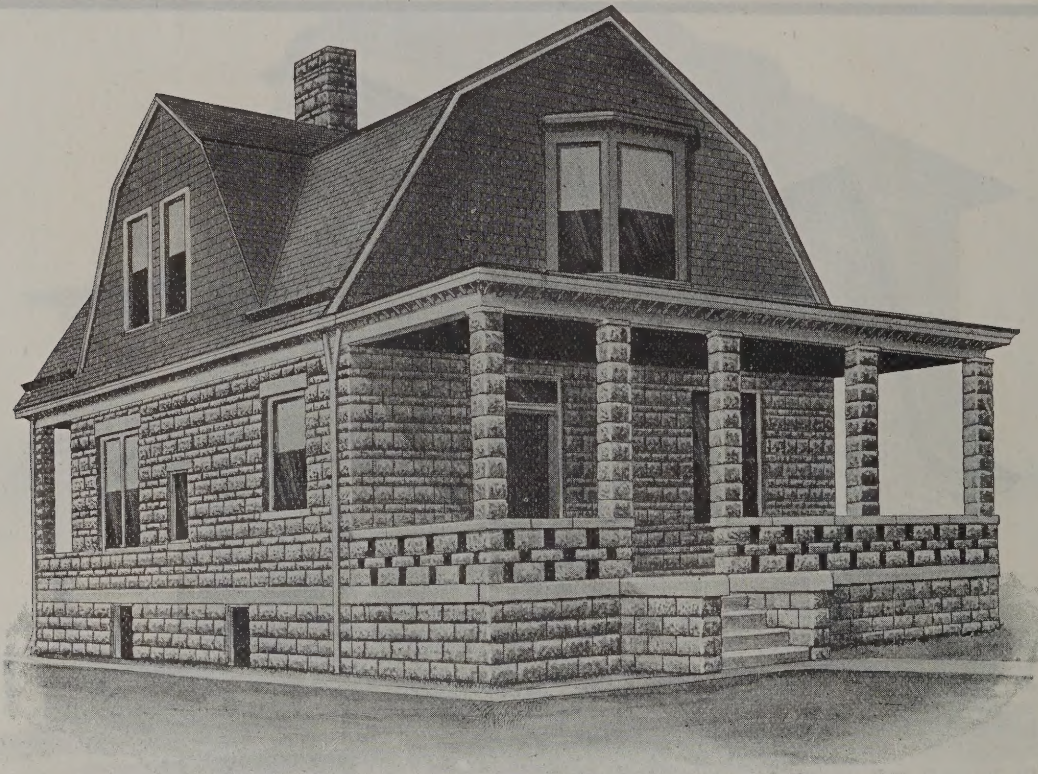
Norman, Okla., Dec. 3, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—In reply to yours of the 26th ult., have to say that I just received the X-L-ALL Cement Block Machine from you and made about 200 blocks and am well pleased with same.

Respectfully yours,
JACOB BODE.

An Attractive Small House



WE PRESENT herewith a reproduction of a photograph sent us by one of our customers illustrating a house erected the past season of 8x8x16-inch hollow cement blocks. Our customer writes us that this cottage is 24x26 feet, and the walls run about 10 feet above the water table. The foundation of this house is made of regular 8x8x16-inch hollow cement blocks and from the water table up the customer has alternated 4-inch and 8-inch face blocks, which make a very nice appearing building. The customer writes us that the 8-inch blocks cost him about 10½ cents to make, and the 4-inch blocks he figures at a proportionate cost. There were about 850 8x8x16-inch blocks and about 550 4x8x16-inch blocks used in the construction of this house. The porch piers were made on one of our 10-inch Buckeye porch post moulds, as shown on another page in this catalogue. The balusters around the porch were made of 4-inch and 8-inch blocks. The cement blocks used in the construction of this house cost about $200.00. In this amount we have included an allowance of about $20.00 for the cost of 150 feet of footing, on which our customer estimated the cost to be about 15 cents per running foot. Think of obtaining the material for building the first story of a house of this size for only $200.00! Understand, this figure represents an approximate cost of the concrete building blocks. There would be an additional charge of from 3 to 5 cents a block, including mortar and labor, in laying them up in the wall.

NEW BALTIMORE CEMENT PLANT,
Manufacturers of Cement Culvert Tile, Blocks, etc.
C. H. MURDICK, Manager.

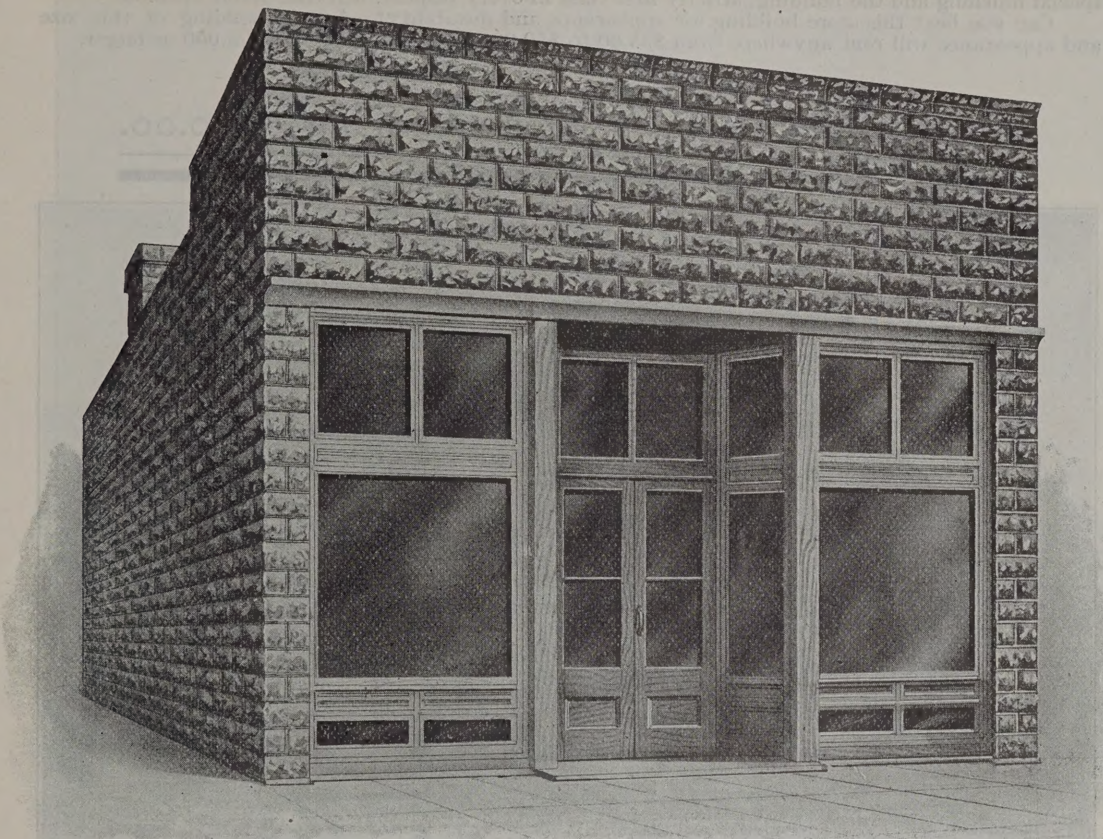
New Baltimore, Mich., Nov. 29, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Your favor of recent date at hand and I note what you say about the cement block business, and in reply have to say that the X-L-ALL Cement Block Machine I bought of you is O. K. and makes a fine block. We use the rock face, and by facing well with richer material we make a block that is waterproof. I shall want some more pallets in the near future. I will also have to have some plates to make circle blocks for round towers, and also want the bay window attachment.

Very truly yours, C. H. MURDICK.

A Modern Cement Block Store Building



WE SHOW herewith an illustration of a model little store building which can be put up at a very moderate expense and which will be up to date, present a fine appearance, require but little expense to maintain the outward appearance of the building and will last for many years. To give you some idea of the cost of a building of this kind we have had a reliable contractor give us some figures which represent a fair cost of material bought in a good, fair market. The price of the materials used in the construction of this building, however, differs in different parts of the country, and what might be a market price in one section of the country might be higher at your point or might be lower, but the figures will serve as an approximate estimate.

We are basing the cost of the materials as follows: Portland cement, $2.00 a barrel; good bank sand and gravel, 50 cents a yard; common labor, $2.00 per day; common lime, 40 cents per bushel; lumber (estimated), $30.00 per thousand.

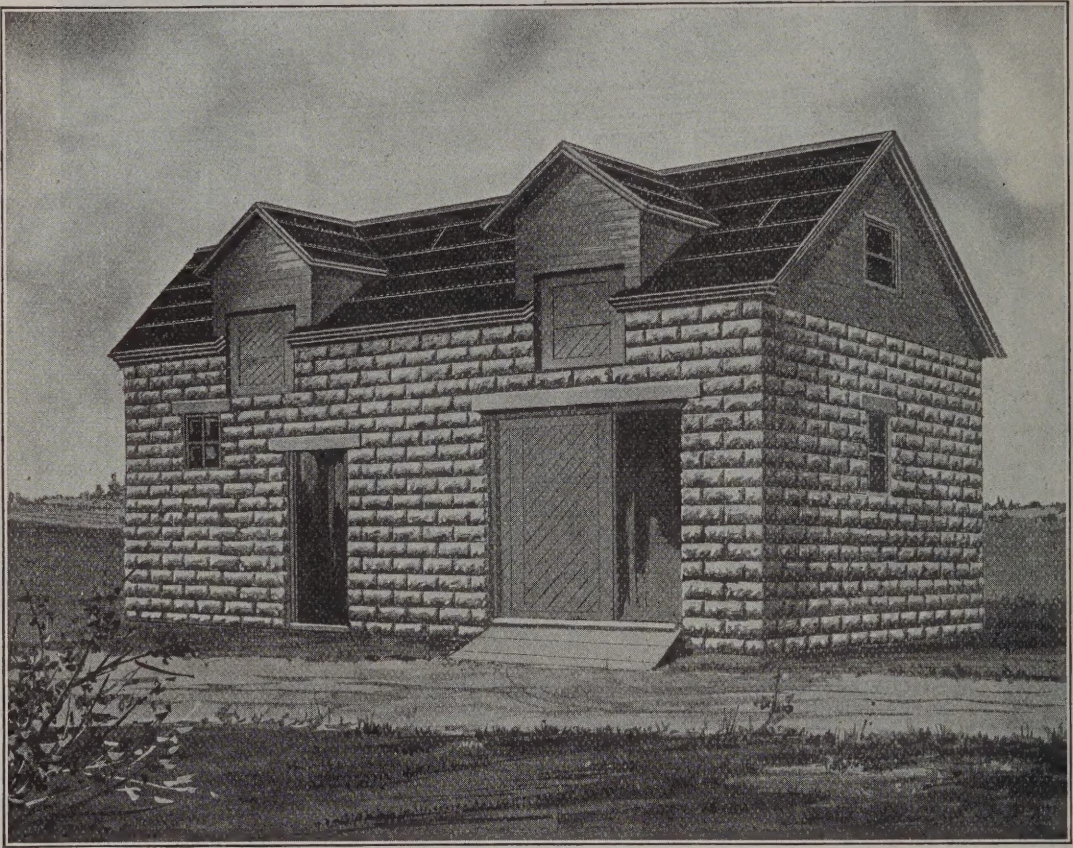
The store shown in the illustration is 26 feet wide, 40 feet long and has an average height of 16 feet and when completed will cost about $750.00. We have based the cost of concrete work on this building along these lines: Using a five-to-one mixture, you will make 32 blocks, size 8x8x24 inches, from one barrel of Portland cement and a half yard of sand and gravel. On this basis the cost of one single block will be about 15 cents. You will probably pay your mason about $4.00 per day and, using a proportion of mortar made of one part cement, one part of lime and two parts of sand, the cost of laying a block 8x8x24 inches, including labor, will be about 4 or 5 cents. We understand many contractors figure a charge of 5 cents in laying blocks, etc. The total cost of the block of this large size in the wall will be about 20 cents.

On a building of this size we estimate the number of blocks, 8x8x24 inches, as being about 1,500. Figuring these blocks at 20 cents each would show a cost of $300 00, the total cost of the blocks laid in the wall. We are figuring on 128 lineal feet of footing or grouting at the base of the foundation, which will probably cost 15 cents per foot, making total cost of $19.20 for this work. We estimate the cost of a 20-foot chimney, made of cement blocks, about $8.00, making a total cost for the foundation, walls and chimney of this modern store building about $330.00.

A carpenter has estimated the probable cost of lumber, including hardwood floors, 2x6-inch joists and a full glass front, as shown in cut, two glass doors in front and one door and two windows in the rear of the building, a metal ceiling of a design as shown in our Special Catalogue of Metal Ceilings, paint for the woodwork, oil for the floors and a good grade of Bestovall Felt Roofing, an iron post or column for the front, which can be obtained in the average locality, a total amount outside of the blocks varying from $250.00 to $300.00. This brings the cost to about $630.00. Add a furnace or special finishing and the building, strictly first class in every respect, will cost about $750.00.

Can you beat this store building for appearance and durability? A store building of this size and appearance will rent anywhere from $25.00 to $50.00 per month in towns of 3,000 or larger.

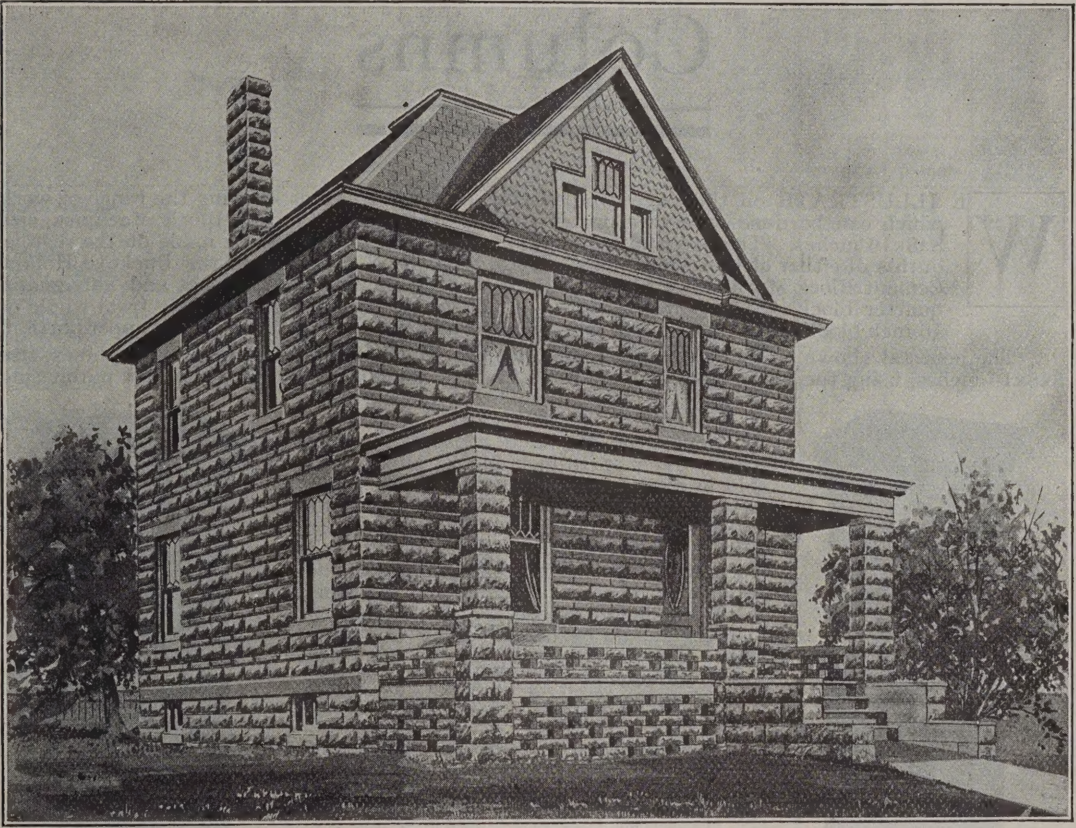
An Attractive Cement Block Barn for $300.00.



THE above illustration shows a barn erected of 8x8x16-inch hollow cement building blocks. This building is about 16 feet wide, 26 feet 8 inches long and 12 feet 8 inches high to the eaves. This building contains stall room for three horses, a large carriage and harness room, besides a large hay mow or loft for storing feed, etc. There are about 1,050 8x8x16-inch blocks used in this building, which cost when cured and dried about 10 cents each, making the total cost of cement blocks used in the wall about $105.00. To work of this kind you would probably add about 3½ or 4 cents for the cost of laying up in the wall, which charge would include the cost of mortar, labor, etc. The door and window sills and caps in this job of work were made in box molds built up on the wall.

The building is covered with our Bestovall Felt Roofing, catalogue No. 63G3033, as shown on page 646 of our large General Catalogue. This roofing is put up in rolls containing 108 square feet, weight about 55 pounds per square of 100 square feet, price, $2.38 per roll. At this price we furnish the roofing complete with nails and a can of Pure Imported Asphalt Roofing Cement. The roof of this building contains about eight squares of roofing, would cost a little less than $20.00. There is but little wood used in the construction of this building. This makes a very desirable barn and it ought to be built in any locality for about $300.00 and at that price it is especially attractive and we doubt if it can be duplicated in any other material for less money.

An Artistic Cement House



The above illustration shows a thoroughly modern residence built entirely of blocks made on our line of Buckeye Machines. The foundation is made of 8x8x16-inch Buckeye Hollow Cement Blocks, while the walls are made of 8x8x16-inch, alternating with 4x8x16-inch rock face hollow cement blocks. The porch piers are made on the Buckeye Porch or Chimney Mould and are 10 inches square. The chimney is built of cement blocks, using plain blocks inside of the house and the rock face as used in the walls from the roof up. Here is a thoroughly modern residence which can be built at a nominal figure in any community.

THE BEST AND HANDIEST CEMENT BLOCK HE EVER SAW.

Blue Hill, Neb.

Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—Your Buckeye Cement Block Machine received, and will say that it is the best and handiest machine of its kind I ever saw. It is very simple and easy to operate and makes what I think is the right size block—just heavy enough and not too heavy—for one man to handle. There is also another point in favor of the 16-inch block. In laying a wall the corners come out right, as the width is just half the length of the block, consequently an extra piece is not required to lay the corner, as a larger block would require. In all, I am well satisfied with my machine.

Yours truly,
HARM ROSE.

Meadville, Mo., Dec. 28, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—I have your letter relating to order for a Buckeye Cement Block Machine. Will say in reply that I find the machine first class in every respect and far in the lead of many other similar machines. It is very easy to operate and with very little danger of spoiling blocks when taking from the mould. I can take a boy and myself and mould 100 blocks per day very easy, and that is less expense than even hauling the brick. The greatest mistake many people make is by not putting enough cement in the sand or gravel; if it is properly proportioned and well mixed, there is no better building material. Hoping this will be of some interest to others in this work, I am,

Yours truly,
B. POTTER.

R. F. D. Box 16, Marshall, Ill., Dec. 12, 1906.

Sears, Roebuck & Co., Chicago, Ill.

Dear Sirs:—In regard to the Buckeye Cement Block Machine I purchased from you, will say it is very satisfactory and does fine work. I have made quite a number of blocks on your machine, all of which were first class in every respect. I have two contracts. One house is completed, and when the other house is completed will send you photographs.

Yours truly,
WM. N. EASTERDAY.

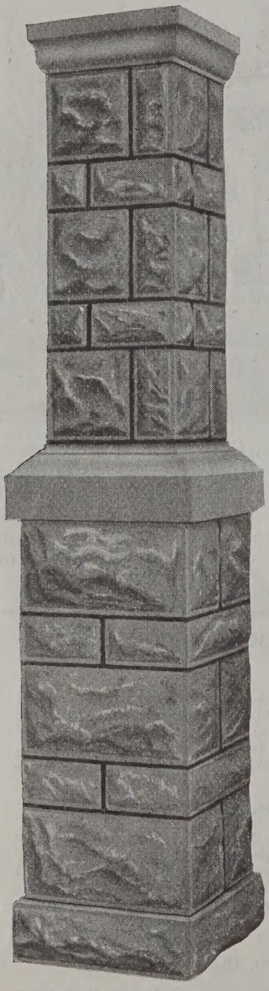
Making Porch Piers and Columns

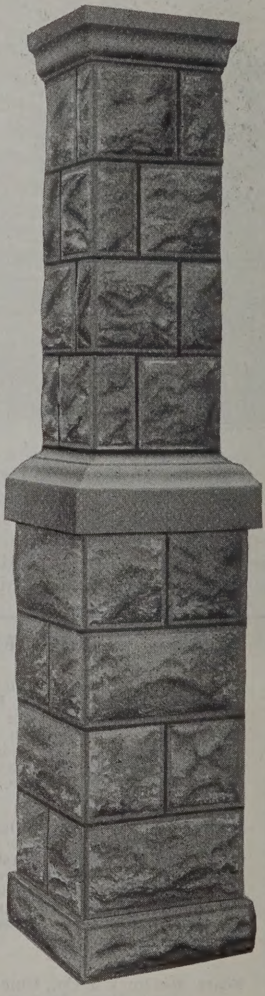
WE ILLUSTRATE on this page two pedestals or porch columns showing the range of work which can be done on either our X-L-ALL or Buckeye Cement Block Machines, size 8x8x16 inches. The pedestal to the right can be built from blocks made on the regular outfits of either of these machines. With both the X-L-ALL and the Buckeye Hollow Cement Block Machine we furnish face plates for making whole blocks and halves and quarter blocks. The pedestal shown in illustration to the right is made from whole or 16-inch blocks in the lower portion and regular half and quarter blocks in the upper portion.

The pedestal shown to the left can be made on either the X-L-ALL or Buckeye machines, size 8x8x16 inches, using the regular outfit as quoted at either $39.00 or $21.25, by simply purchasing extra face plate and ends for making rock face blocks, size 4x8x16 inches. The lower portion of the left hand pedestal is made from whole or 16-inch blocks and 4-inch blocks of the same length. The first layer above the base of both of these pedestals is made by using the rock face plate for whole blocks and right hand and left hand rock end doors. The second course of the right hand pedestal is made from the same blocks laid crosswise. The alternating courses should be laid up along the same line. The second course on the left hand pedestal is made with 4x8x16-inch blocks, rock face design, laid up the same as the other one.

The upper section of the right hand pedestal is made from half blocks and quarter blocks made on the regular 8x8x16-inch rock face plate for making halves and quarters. The upper section of the left hand pedestal is made from regular half and quarter blocks, both from the regular 8x8x16-inch face plate and from the special face plate for making 4x8x16-inch blocks. The photographs reproduced here show how easy it is to lay up porch piers or columns from the regular outfits furnished with our standard machines. It is not necessary to buy separate moulds, flasks or dies at a big expense to do this kind of work, because they can all be made on the regular machine as furnished by us.

Why go to the expense of several hundred dollars to buy a mass of complicated machinery only to throw away in the scrap pile after a few months' work? Buy an up to date, first class cement block machine, made by experienced workmen and constructed along thorough mechanical principles. We have no county or state rights to unload on you, neither do you have to mortgage your farm or place of business to secure the funds necessary to start you in the most profitable and pleasant business now known.





Every piece of concrete working machinery in this catalogue is fully warranted and you run no risk in purchasing a machine or any part of an outfit because you can return to us at our expense any machine not entirely satisfactory after giving our machine a fair trial, and we will refund your money.

Freight Rate Table of Cement Block and Brick Machines, Concrete Mixers and Accessories

STATE	Part of State	X-L-ALL Cement Block Machines Per 100 pounds	X-L-ALL Cement Mixers Per 100 pounds	Minimum Freight Charges	Buckeye Cement Block Machines Per 100 pounds	Clover Leaf Cement Mixers Per 100 pounds	Buckeye Cement Block Machines Minimum Freight Charges
ALABAMA—							
Birmingham	Cent.	$0.80	$0.80	$0.80	$0.90	$0.90	$0.90
Florence	N. W.	.80	.80	.80	.90	.90	.90
Mobile	S. W.	.75	.75	1.10	.79	.79	1.16
Fort Payne	N. E.	1.00	1.00	1.00	1.00	1.00	1.00
Midland City	S. E.	1.46	1.46	1.45	1.56	1.51	1.45
ARIZONA—							
Holbrook	N. E.	3.39	3.74	1.97	3.66	5.72	2.38
Kingman	N. W.	3.40	3.90	1.97	3.67	5.96	2.38
Phoenix	Cent.	3.33	3.79	1.94	3.52	5.99	2.14
Tombstone	S. E.	3.16	3.58	1.94	3.32	5.69	2.14
ARKANSAS—							
Fayetteville	N. W.	1.19	1.30	1.30	1.35	1.99	1.52
Hope	S. W.	1.23	1.37	1.37	1.54	2.17	1.64
Jonesboro	N. E.	.78	.93	.93	.97	1.70	1.13
Little Rock	Cent.	1.01	1.20	1.20	1.20	2.10	1.40
Pine Bluff	S. E.	1.01	1.20	1.20	1.20	2.10	1.40
CALIFORNIA—							
Redding	North.	3.16	3.61	2.85	3.16	5.42	2.85
San Bernardino	South.	2.90	3.34	2.85	2.90	5.01	2.85
Stockton	Cent.	2.60	3.00	2.60	2.60	4.50	2.60
COLORADO—							
Colorado Springs	Cent.	1.65	2.05	.75	1.92	3.19	1.16
Glenwood Springs	N. W.	2.87	3.42	1.97	3.14	5.24	2.38
La Junta	S. E.	1.65	2.05	.75	1.92	3.19	1.16
Silverton	S. W.	3.20	3.75	2.30	3.47	5.74	2.71
Sterling	N. E.	1.58	1.81	.75	1.85	2.83	1.16
CONNECTICUT—							
New Haven	S. W.	.82	.71	.82	.64	.56	.64
Putnam	N. E.	.82	.71	.82	.64	.56	.64
New Britain	South.	.82	.71	.82	.64	.56	.64
Winsted	N. W.	.82	.71	.82	.64	.56	.64
DELAWARE—							
Dover	Cent.	.75	.65	.75	.57	.50	.57
DISTRICT OF COLUMBIA—							
Washington	Cent.	.72	.62	.72	.54	.47	.54
FLORIDA—							
Jacksonville	N. E.	.97	.97	.83	1.07	1.02	.90
Pensacola	West.	.75	.75	1.10	.79	.79	1.16
Tarpon Springs	S. W.	1.63	1.63	1.22	1.75	1.70	1.29
GEORGIA—							
Camilla	S. W.	1.36	1.36	1.15	1.46	1.41	1.22
Macon	Cent.	1.03	1.03	.79	1.13	1.08	.86
Rome	N. W.	1.00	1.00	.77	1.10	1.05	.84
Savannah	S. E.	.97	.97	.83	1.07	1.02	.90
Toccoa	N. E.	1.08	1.08	.81	1.18	1.13	.88
IDAHO—							
Boise	S. W.	2.80	3.30	2.40	3.07	5.06	2.81
Montpelier	S. E.	2.40	2.85	2.08	2.75	4.54	2.49
Wallace	North	3.10	3.60	2.85	3.51	5.25	3.26
ILLINOIS—							
Bloomington	Cent.	.29	.27$\frac{1}{10}$	.25	.43	.37	.43
Freeport	N. W.	.44	.25$\frac{9}{10}$	.25	.59	.52	.59
Peoria	N. E.	.44	.28$\frac{9}{10}$	.25	.43	.37	.43
Mt. Carmel	S. E.	.42	.34$\frac{3}{10}$	.25	.47	.41	.47
Murphysboro	S. W.	.43	.36$\frac{9}{10}$	.25	.53	.47	.53
INDIANA—							
Auburn	N. E.	.29	.25	.29	.33	.29	.33
Evansville	S. W.	.40	.34	.40	.47	.41	.47
Frankfort	Cent.	.30	.25	.30	.40	.34	.40
North Judson	N. W.	.18	.16	.25	.39	.33	.39
North Vernon	S E.	.39	.33	.39	.41	.35	.41
INDIAN TERRITORY—							
Tishomingo	S. W.	1.29	1.50	.95	1.48	2.36	1.09
South McAlester	Cent.	1.20	1.40	.74	1.43	2.21	.94
Vinita	N. W.	1.03	1.25	.60	1.43	1.99	.94

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STATE	Part of State	X-L-ALL Cement Block Machines	X-L-ALL Cement Mixers	Minimum Freight Charges	Buckeye Cement Block Machines	Clover Leaf Cement Mixers	Buckeye Cement Block Machines
		Per 100 pounds	Per 100 pounds		Per 100 pounds	Per 100 pounds	Minimum Freight Charges
IOWA—							
Marshalltown	Cent.	$0.50	$0.63	$0.25	$0.83	$1.06	$0.66
Mt. Pleasant	S. E.	.48	.57	.25	.74	.88	.66
New Hampton	N. E.	.50	.60	.25	.81	1.00	.66
Red Oak	S. W.	.65	.80	.25	.92	1.31	.66
Sheldon	N. W.	.65	.80	.25	.92	1.31	.66
KANSAS—							
Colby	N. W.	1.43	1.66	.50	1.70	2.60	.91
Great Bend	Cent.	1.27	1.52	.50	1.54	2.39	.91
Manhattan	N. E.	1.00	1.20	.50	1.27	1.91	.91
Parsons	S. E.	.86	1.05	.50	1.13	1.69	.91
Syracuse	S. W.	1.50	1.75	.50	1.77	2.74	.91
KENTUCKY—							
Greenup	East.	.37	.39	.37	.37	.32	.37
Junction City	Cent.	.65	.60	.65	.62	.57	.62
Princeton	West.	.52	.52	.77	.81	.75	.82
LOUISIANA—							
Alexandria	Cent.	1.10	.99	.78	1.29	2.25	.87
Lake Charles	S. W.	1.25	1.02	.85	1.44	2.55	.94
Monroe	N. E.	1.10	.99	.78	1.29	2.25	.87
New Orleans	S. E.	.75	.75	1.10	.79	.79	1.16
Shreveport	N. W.	1.10	.99	.78	1.29	2.25	.87
MAINE—							
Ashland	North.	1.58	1.27	1.58	1.40	1.12	1.40
Dover	Cent.	1.02	.89	1.07	.84	.73	.89
Lewiston	South.	.82	.71	.82	.64	.55	.64
MARYLAND—							
Baltimore	N. E.	.72	.62	.72	.54	.47	.54
Hagerstown	N. W.	.72	.62	.72	.54	.47	.54
Salisbury	S. E.	.75	.65	.75	.57	.47	.57
Upper Marlboro	S. W.	.75	.65	.75	.57	.50	.57
MASSACHUSETTS—							
Boston	East.	.82	.71	.82	.64	.55	.64
Pittsfield	West.	.82	.71	.82	.64	.55	.64
Rutland	Cent.	.82	.71	.82	.64	.55	.64
MICHIGAN—							
Au Sable	N. E.	.56	.45	.56	.57	.50	.57
Detroit	S. E.	.37	.32	.37	.32	.27	.32
Lansing	Cent.	.36	.31	.36	.39	.33	.39
Manistee	N. W	.47	.41	.47	.43	.37	.43
Marquette	North.	.60	.50	.25	.91	.75	.66
Niles	S. W.	.22	.20	.25	.40	.34	.40
MINNESOTA—							
Crookston	N. W.	1.07	1.19	.50	1.48	1.76	.91
Duluth	N. E.	.55	.65	.25	.91	.75	.66
Faribault	S. E.	.50	.60	.25	.91	.75	.66
Redwood Falls	S. W.	.55	.65	.25	.96	1.18	.66
St. Cloud	Cent.	.79	.84$\frac{8}{10}$	.50	1.20	1.26	.91
MISSISSIPPI—							
Brookhaven	S. W.	.93	.93	.50	1.14	1.08	1.03
Durant	Cent.	.82	.82	.50	1.03	.97	1.03
Hattiesburg	S. E.	.95	.95	1.38	1.28	1.22	1.28
Sardis	N. W.	.77	.77	.77	.98	.92	1.03
Tupelo	N. E.	.78	.78	.78	.99	.93	1.03
MISSOURI—							
Albany	N. W.	.65	.80	.25	.92	1.31	.66
Edina	N. E.	.52	.65	.25	.82	.98	.66
Jefferson City	Cent.	.58	.71	.50	.83	1.09	.72
Poplar Bluff	S. E.	.66	.77	.50	.85	1.03	.72
Springfield	S. W.	.72	.82	.50	.99	1.34	.72
MONTANA—							
Dillon	S. W.	2.40	2.85	2.15	2.81	4.13	2.56
Glasgow	N. E.	1.86	2.24	1.61	2.27	3.21	2.80
Kalispell	N. W.	2.51	2.96	2.26	2.92	4.29	2.67
Lewistown	Cent.	2.90	3.35	2.65	3.31	4.88	3.06
Miles City	S. E.	1.90	2.25	1.65	2.31	3.25	2.06

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		Per 100 pounds	Per 100 pounds		Per 100 pounds	Per 100 pounds	Minimum Freight Charges
NEBRASKA—							
Beatrice	S. E.	$0.77	$0.92	$0.50	$1.04	$1.49	$0.91
Crawford	N. W.	1.76	2.02	.50	2.03	3.14	.91
Norfolk	N. E.	.95	1.15	.50	1.22	1.84	.91
Sidney	S. W.	1.58	1.81	.50	1.85	2.83	.91
Thedford	Cent.	1.36	1.58	.50	1.63	2.48	.91
NEVADA—							
Caliente	S. E.	3.57	4.14	3.17	3.89	6.36	3.83
Elko	N. E.	3.40	3.90	3.40	3.72	6.00	3.72
Reno	West.	3.40	3.90	3.40	3.72	6.00	3.72
NEW MEXICO—							
Albuquerque	Cent.	1.80	2.32	1.51	1.99	3.47	1.60
Carlsbad	S. E.	1.99	2.29	1.70	2.31	3.59	2.11
Deming	S. E.	2.14	2.39	1.45	2.50	3.74	1.86
Gonzales	N. W.	2.83	3.11	2.10	3.15	4.81	2.51
Las Vegas	N. E.	2.10	2.32	1.95	2.42	3.63	1.93
NEW HAMPSHIRE—							
Berlin	North.	.82	.71	.82	.64	.55	.64
Nashua	South.	.82	.71	.82	.64	.55	.64
Plymouth	Cent.	.82	.71	.82	.64	.55	.64
NEW JERSEY—							
Bridgeton	South.	.80	.70	.80	.62	.55	.62
Freehold	Cent.	.80	.70	.80	.62	.55	.62
Paterson	North.	.75	.65	.75	.57	.49	.57
NEW YORK—							
Little Falls	Cent.	.72	.62½	.72	.54	.47	.55
Oswego	S. W.	.60	.52	.60	.44	.38	.44
Plattsburg	N. E.	1.10	.92	1.10	.93	.81	.79
Poughkeepsie	S. E.	.75	.65	.75	.57	.49	.57
Watertown	N. W.	.75	.65	.75	.57	.49	.57
NORTH CAROLINA—							
Raleigh	Cent.	.86	.86	.86	.96	.91	.96
Shelby	S. W.	1.08	1.08	1.08	1.18	1.13	1.18
Tarboro	N. E.	.79	.79	.79	.89	.84	.89
Wilkesboro	N. W.	.96	1.20	.96	1.06	1.01	1.06
Wilmington	S. E.	.75	.70	.75	.85	.80	.85
NORTH DAKOTA—							
Carrington	Cent.	1.29	1.45	.50	1.70	2.15	.91
Dickinson	S. W.	1.58	1.87	.50	1.99	2.66	.91
Ellendale	S. E	1.03	1.19	.25	1.44	1.91	.66
Grafton	N. E.	1.17	1.27	.50	1.58	1.94	.91
Minot	N. W.	1.49	1.70	.50	1.90	2.48	.91
OHIO—							
Dayton	S. W.	.40	.34	.40	.25	.22	.25
Defiance	N. W.	.33	.28½	.33	.32	.28	.32
Gallipolis	S. E.	.45	.39	.45	.34	.30	.34
Mt. Vernon	Cent.	.41	.35	.41	.08	.08	.25
Warren	N. E.	.44	.37½	.44	.30	.26	.30
OKLAHOMA—							
El Reno	Cent.	1.29	1.50	.89	1.44	2.55	1.24
Enid	North.	1.29	1.50	.87	1.44	2.55	1.24
Lawton	South.	1.29	1.50	.95	1.48	2.55	1.24
OREGON—							
Pendleton	N. E.	3.10	3.60	2.85	3.51	5.25	2.85
Portland	N. W.	2.60	3.00	2.60	2.60	4.50	2.60
Roseburg	S. W.	3.24	3.72	2.85	3.24	5.58	2.85
PENNSYLVANIA—							
Emporium	N. E.	.56	.48	.56	.42	.36	.42
Franklin	N. W.	.45	.39	.45	.39	.33	.39
Harrisburg	Cent.	.72	.62	.72	.54	.47	.54
Reading	S. E.	.73	.63	.73	.55	.48	.55
Pittsburg	S. W.	.45	.39	.45	.32	.27	.32
RHODE ISLAND—							
Providence	Cent.	.82	.71	.82	.64	.55	.64

Freight Rate Table of Cement Blocks and Brick Machines, Concrete Mixers and Accessories—Continued

STATE	Part of State	X-L-ALL Cement Block Machines	X-L-ALL Cement Mixers	Minimum Freight Charges	Buckeye Cement Block Machines	Clover Leaf Cement Mixers	Buckeye Cement Block Machines
		Per 100 pounds	Per 100 pounds		Per 100 pounds	Per 100 pounds	Minimum Freight Charges
SOUTH CAROLINA—							
Allendale	S. W.	$1.27	$1.26½	$1.05	$1.37	$1.32	$1.12
Bennettsville	N. E.	1.04	1.04	.90	1.14	1.09	.97
Charleston	S. E.	.97	.97	.95	1.07	.92	1.02
Columbia	Cent.	1.03	1.03	.90	1.13	1.08	.97
Spartanburg	N. W.	1.08	1.08	.92	1.18	1.13	.99
TENNESSEE—							
Jackson	West.	.70	.70	.50	.95	.89	.88
McMinnville	Cent.	.93	.93	.83	1.11	1.05	1.01
Morristown	East.	1.04	1.04	.94	1.14	1.09	1.01
TEXAS—							
Amarillo	N. W.	1.46	1.67	1.13	1.65	2.62	1.22
Beaumont	S. E.	1.37	1.57	1.06	1.56	2.42	1.15
Kerrville	Cent.	1.44	1.64	1.64	1.63	2.57	1.18
Marfa	S. W.	1.67	1.94	1.37	1.86	2.97	1.46
Paris	N. E.	1.37	1.57	1.06	1.56	2.42	1.15
UTAH—							
Ogden	North.	2.40	2.85	2.00	2.67	4.39	2.47
Provo City	Cent.	2.40	2.85	2.00	2.67	4.39	2.47
Richfield	South.	2.80	3.27	2.40	3.07	5.02	2.87
VERMONT—							
Bennington	South.	.82	.71	.82	.64	.55	.64
Middlebury	Cent.	.82	.71	.82	.64	.55	.64
Newport	North.	.82	.71	.82	.64	.55	.64
VIRGINIA—							
Calverton	N. W.	.89	.84	.97	.72	.64	.80
Charlottesville	Cent.	.72	.62	.72	.55	.47	.55
Rocky Mount	S. W.	.76	.83½	.66	.73	.68	.73
Suffolk	S. E.	.72	.62	.72	.55	.47	.55
WASHINGTON—							
Chehalis	S. W.	2.60	3.00	2.60	2.60	4.50	2.60
Colville	N. E.	3.58	3.50	3.10	3.99	5.63	3.51
Mt. Vernon	N. W.	2.60	3.00	2.60	2.60	4.50	2.60
Walla Walla	S. E.	3.10	3.60	2.85	3.51	5.25	3.26
Wenatchee	Cent.	3.10	3.85	2.85	3.30	5.25	2.85
WEST VIRGINIA—							
Elkins	Cent.	.72	.72	.72	.54	.46	.54
Martinsburg	South.	.72	.62	.72	.54	.46	.54
Ronceverte	South.	.72	.62	.72	.54	.46	.54
Wayne	West.	.84	.72	.84	.66	.56	.66
WISCONSIN—							
Grand Rapids	Cent.	.42	.50	.25	.83	.71	.66
La Crosse	S. W.	.42	.50	.25	.83	.71	.66
Marinette	N. E.	.55	.43	.25	.76	.75	.66
Milwaukee	S. E.	.33	.25	.25	.43	.37	.43
Superior	N. W.	.55	.65	.25	.91	.75	.66
WYOMING—							
Casper	Cent.	2.19	2.62	.75	2.46	4.04	1.16
Granger	S. W.	2.65	2.85	2.00	2.92	4.76	2.41
Laramie	S. E.	2.10	2.56	1.25	2.37	3.96	1.66
Minturn	N. E.	2.13	2.70	.75	2.40	3.89	1.16

MAKES JUST AS GOOD BLOCKS AND JUST AS MANY AS CAN BE MADE ON ANY HIGH PRICED MACHINE.

Minneola, Kans., Dec. 1, 1906.

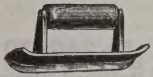
Sears, Roebuck & Co., Chicago, Ill.

Gentlemen:—I am using one of your X-L-ALL Block Machines which I purchased from you last May. I can make just as good blocks and just as many of them on your X-L-ALL machine as can be made on any high priced machine that was ever sold. Your machine makes the face down, which is always a better block than can be made on a perpendicular or side faced machine. I like the X-L-ALL machine all right and I saved at least $30.00 on the machine and 125 pallets by buying the outfit from Sears, Roebuck & Co. Send me your catalogue of extra attachments and other sizes of cement block machines. Yours truly,

DAVID STEVENS.

Cement Workers' Tools

Cement Edgers.



No. 24G9440 This tool is used for finishing the edges of sidewalks. Accurately shaped, smooth finish, nickel plated. Weight, 1¼ pounds.

Size, inches	⅜	¾
Price	38c	44c

Bronze Cement Edgers.

No. 24G9440½ Solid Bronze Cement Edgers will outwear a half dozen cast edgers. Finely finished and polished. 6 inches long, 3 inches wide, ⅜-inch radius. Weight, 1 pound.
Price..75c

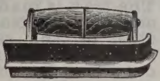
Cement Groovers.

No. 24G9441 Cement Sidewalk Groovers or Joiners. Curved at both ends, smoothly finished. Furnished all cast or steel center, as desired, nickel plated. Weight, 1⅛ pounds.
Price, steel center, 59c; all cast................37c

Bronze Cement Groovers.

No. 24G9441½ Solid Bronze Double Round End Cement Groovers will outwear a half dozen cast groovers. Finely finished and polished. 5½ inches long, 2⅝ inches wide. Weight, 1 pound.
Price, each..75c

Cement Centers.

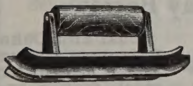


No. 24G9442 Cement Sidewalk Centers. Curved at one end, square at the other. Furnished all cast or steel center, as desired. Nickel plated. Weight, 1⅛ pounds.
Price, steel center, 59c; all cast................37c

Bronze Cement Centers.

No. 24G9443½ Solid Bronze Cement Centers will outwear a half dozen cast tools. Finely finished and polished. Length, 6 inches; width, 2⅝ inches. Weight, 1⅛ pounds.
Price..75c

Drive Way Groovers.

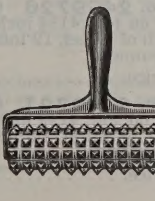


No. 24G9442½ Cement Drive Way Groovers. All cast, curved at both ends. Nickel plated. Weight, 1 pound 6 ounces.
Price....................45c

Bronze Drive Way Groovers.

No. 24G9444½ Solid Bronze Drive Way Groovers will outlast a dozen common cast groovers. Finely finished and polished. Cuts heavy groove ½ inch deep. Weight, 1¼ pounds.
Price..75c

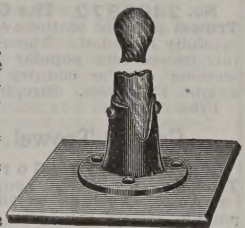
Acme Improved Sidewalk Rollers.



No. 24G9443 Acme Improved Sidewalk Rollers, made of bronze, cast on steel bearings, by a special process. This makes a heavy, perfect roller for a little money.

Size, 3½ inches diameter by 10 inches long. Weight, 10 pounds.
Price................$6.25

Sand Tampers.

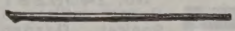


No. 24G9444 Improved Steel Tampers. Malleable iron flange attached to a steel plate. Has a perfectly shaped handle.

Size, 8x8 inches; weight, 14 pounds.
Price................62c

Size, 10x10 inches; weight, 18 pounds.
Price................82c

Our Little Steel Handy Pinch Bars.



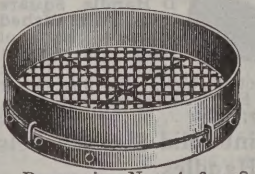
No. 24G9445 It is the real thing for use about store, warehouse, factory, barn, on truck (teaming), or about house or farm. You can move almost anything with one of them. Handy everywhere, and a single use when you need it will save many times the trifling cost. It is hammered steel, ¾-inch in the square, 3 feet long, with tempered points, as shown in illustration. Weight, 3¾ pounds.
Price, black....................................30c
Full polished....................................47c

Masons' Tool Bags.

No. 24G9392 Masons' Canvas Tool Bags. Heavy, solid frame; leather handle; a good, durable bag. No mason should be without one. Average weight, 2½ pounds.

Size..	18 in.	20 in.	24 in.
Price	$1.50	$1.60	$1.95

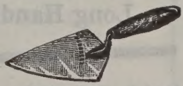
Foundry Riddles.



No. 24G9394 Foundry Riddles. Wood rims with brass or steel wire. Sieves made of heavy wire with extra strong rims. Weight, 2¼ pounds.
Steel wire, Nos. 4, 6 or 8. Price................44c
Brass wire, Nos. 4, 6 or 8. Price................70c

Brick Trowels.

Our Brick Trowels are made with great care by experienced workmen from the best steel—tempered to stand the most severe usage. They are forged from the bar, shank and blade all one piece. We do not handle the cheap trowel with stamped blade riveted to shank.



No. 24G9364 The Fulton Masons' Brick Trowel, London pattern. Finely finished and correctly tempered. Average weight, 13 ounces. Warranted.

Size, inches	10	10½	11
Price	35c	39c	42c

No. 24G9365 The Fulton Masons' Brick Trowel, Philadelphia pattern, has square heel which brings weight of mortar nearer the hand. Warranted. Average weight, 14 ounces.

Size, inches	10	10½	11
Price	36c	40c	43c

Pointing Trowels.

No. 24G9366 The Fulton Pointing Trowel, same shape as No. 24G9364 trowel, only smaller, forged steel blade, polished, welded to shank. Warranted. Average weight, 4 ounces.

Size, inches	4	5	6
Price	16c	18c	19c

Cement Workers' Tools—Continued

Plastering Trowels.

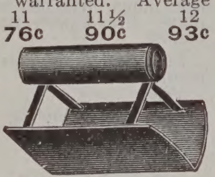
No. 24G9369 The Fulton Plastering Trowel is made of the very best of steel, finely finished and handled so it will balance right. Fully warranted. Average weight, 1 pound.

Size, inches	10	10½	11	12
Price	**36c**	**42c**	**43c**	**50c**

No. 24G9372 The Cincinnati Pattern Plastering Trowel is made of the very best steel, extra fine finish, carefully mounted. The easy fit to the hand has made this trowel very popular with the best plasterers in all sections of the country. Fully warranted. Average weight, 17 ounces.

Size, inches	11	11½	12
Price	**76c**	**90c**	**93c**

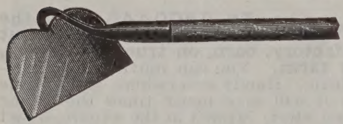
Corner Trowel.



No. 24G9377 Corner Trowels, cast steel. Length, 6 inches. Average weight, ½ pound.

Price................**40c**

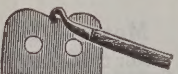
Socket Garden Hoes.



No. 24G9291 Common Shaped Socket Garden Hoes, with cast steel blade welded to socket. Selected handle, full regular size, 7½-inch blade. Weight, 2½ pounds. Price, each.........**32c**

Price, for 3 hoes.............................**93c**

Solid Shank Mortar Hoes.

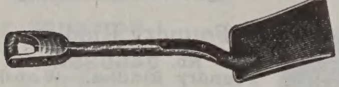


No. 24G9294 Solid Shank Mortar Mixer. Finest hoe made for mixing mortar. Also an excellent hoe for cleaning irrigating ditches, as it allows the water to pass through the holes while the mud and refuse are drawn out. Blade, 10 inches wide. Weight, 4½ pounds.

Price..**50c**

No. 24G9295 Same as above, without holes in blade. Price....................................**47c**

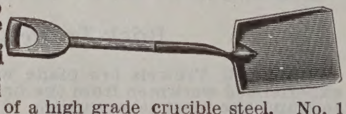
Square Point Plain Back Shovels.



No. 24G9128 D Handle Square Point Full Polished Shovels. Made of solid crucible cast steel. Plain back socket straps. Made of selected stock. Nothing better made. Size, 9¾x12 inches. Every shovel warranted.

Price, for 3 shovels, **$1.60;** each...............**56c**

Silver King Square Point Solid Steel Shovels with D Handles.



No. 24G9130 Silver King Square Point, D Handle, Solid Steel Maynard Pattern Shovels. Solid steel socket. Made of a high grade crucible steel. No. 1 handles, finely polished. A strictly high grade shovel.

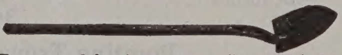
Price, for 2 shovels, **$1.58;** each...............**82c**

Long Handle Square Point Shovels.

No. 24G9136 Long Handle Square Point Full Polished Shovels. Made of solid crucible cast steel. Plain smooth back and socket straps, same grade as our No. 24G9128. Every shovel warranted. Best selected hickory handles.

Price, for 3 shovels, **$1.60;** each.............**56c**

Long Handle, Round Point Shovels.



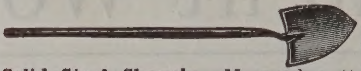
No. 24G9143 Long Handle, Round Point Shovels, all steel. Front and back straps. Size, 9¾x12 inches, full regular size. Weight, about 6 pounds.

Price, for 3 shovels, **$1.38;** each...............**48c**

No. 24G9145 Long Handle, Round Point, Full Polished, Solid Crucible Cast Steel Shovels. Plain, smooth back socket straps. Made of the finest cast steel. Nothing better made. Full warranted.

Price, for 3 shovels, **$1.60;** each..............**56c**

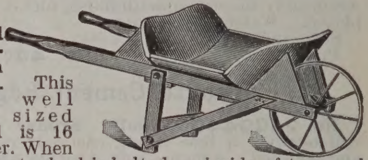
Silver King Round Point Solid Steel Shovels.



No. 24G9146 Silver King, Long Handle, Round Point, Solid Steel Shovels. Maynard pattern. Solid socket shank. Made of a high grade crucible steel. No. 1 handles. Full polished. A strictly high grade shovel.

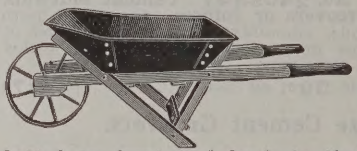
Price, for 2 shovels, **$1.60;** each..............**85c**

Wheelbarrows.



No. 24G9701 Half Bolted Railroad Wheelbarrow, with steel wheel. This wheelbarrow is well made. Has full sized tray; the wheel is 16 inches in diameter. When packed for shipment wheel is bolted on inside of tray and legs are folded on side of handle. Can be easily set up by anyone. Weight, 45 pounds. Price......**$1.29**

Acme Steel Tray Wheelbarrow.

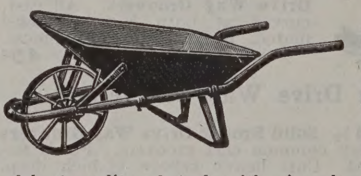


No. 24G9704 This steel tray barrow is strong and substantial. Has a well made steel tray, mounted on our Acme Special frame bolted in front and back to the braces. Has a 5-16-inch rod turned under edge of tray. Frame is bolted and well braced. Has a 16-inch steel wheel. Weight, 45 pounds. Price.....................**$2.15**

Heavy Steel Tray Barrow.

No. 24G9723 The tray is made of one piece of No. 16 steel of the same thickness throughout. The edges of the tray are flanged and turned over a 5-16-inch steel rod. This rod prevents the tray from breaking at the edge and makes it **very much stronger.** As the steel of the tray is of uniform thickness there are **no thin corners to give out after using a short time.** These barrows are made to dump forward and are so constructed that at the dumping point they will not run back on the operator. They are well bolted and braced and made of the **best material and painted.** The wheel revolves on a heavy bolt which also passes through the handles and so materially strengthens the barrow. Weight, 70 pounds. Price...........**$4.75**

Solid Pressed Steel Tray Barrow.



Coal and Coke Barrow, with one piece tubular steel frame extending around in front of the wheel. Frame strongly braced and well ironed. The tray is made of best quality of steel, with wire edge. They will carry from 400 to 450 pounds of coal or five bushels of coke. Fitted with our extra heavy No. 4 wheel, 17 inches in diameter, tire 2¼x7-16-inch, nine 9-16-inch spokes, ¾-inch axle.

No. 24G9726 Gauge of steel in tray, 15; length of tray on top, 41½ inches; width of tray on top, 33 inches; depth of wheel, 12 inches; capacity, 6 cubic feet. Weight. 95 pounds.

Price.......................................**$7.35**

No. 24G9727 Gauge of steel in tray, 13; length of tray on top, 41½ inches; width of tray on top, 33 inches; depth of wheel, 12 inches; capacity, 6 cubic feet. Weight, 110 pounds.

Price.......................................**$8.75**

Opinions from Users of the Buckeye Cement Block Machines

Sears, Roebuck & Co., Chicago, Ill. Kankakee, Ill., Dec. 10, 1906.

Dear Sirs:—I have received your letter of recent date asking how I like my Buckeye Cement Block Machine I purchased of you. I like it better than any machine I ever saw. It is first class in every respect; it makes the nicest and strongest blocks we have used in town. I am more than satisfied with my purchase.

Yours truly, L. SUPRENANT.

Sears, Roebuck & Co., Chicago, Ill. Moscow, Ky., Dec. 1, 1906.

Dear Sirs:—The Buckeye Cement Block Machine that I bought of you some time ago was all O. K. and I certainly am well pleased with it. The machine is easy to work and with no set screws or gears to bother with. The P——————Co. sent a nice machine here for me to try. It weighed 1,000 pounds and the agent wanted $300.00 for it. I find that your Buckeye machine makes just as good a block and it makes them faster than the big, high priced machine. I am going to start a cement block yard in the spring and I will want two more Buckeye machines just like this one and will want larger machines for foundation work and heavier walls. I am using the 8x8x16-inch Buckeye machine now. Please send me your new catalogue and keep me posted about the new things you get out for cement block machines. Yours truly, J. M. SHUBERT.

THE VALLEY POULTRY YARDS,
Van Volkenburg Bros., Mgrs.

Sears, Roebuck & Co., Chicago, Ill. Freeland, Mich., Nov. 30, 1906.

Dear Sirs:—Your letter received and in regard to the Buckeye Cement Block Machines, they are the fastest block machines I ever saw and make the best blocks. I bought mine to build poultry houses with. About becoming damp, I think there is very little danger if the blocks are made right. Some have trouble with blocks cracking when taking them out of the machine, but there is no trouble with the Buckeye machine. I have had them tell me they have to cut wires and put in the machines in order to keep the blocks from cracking, but with the Buckeye there is no trouble. Be sure and have a level place to put the blocks while on the pallets curing and there is no trouble with cracking blocks. Yours very truly, BERT VAN VOLKENBURG.

Sears, Roebuck & Co., Chicago, Ill. Ashtabula, Ohio, Dec. 14, 1906.

Kind Sirs:—I would say in regard to the Buckeye Cement Block Machine I purchased from you, that we are well pleased with it. I am a stone mason and I like the blocks that we make with your machine better than any others. The machine is all right Yours truly, OLEFA COSLEW.

Sears, Roebuck & Co., Chicago, Ill. Lapeer, Mich., Dec. 3, 1906.

Sirs:—You ask my opinion on cement blocks and machines. I bought a Buckeye machine from you people and find it the best I ever used. I have used several different kinds.

Yours truly, M. E. RICKERT.

Sears, Roebuck & Co., Chicago, Ill Ord, Neb., Dec. 3, 1906.

Gentlemen:—I am well pleased with the Buckeye Cement Block Machine. Think there is none better on the market and the price puts it within the reach of all who are in need of cement block machinery. Would not trade for any of the higher priced machines on the market. All the machines that are put on the market that make blocks with the face on the side are a failure. Bought your machine for my own use. Am building a block house. Everyone that sees the blocks says they are all O. K. I do not think that the walls will be damp if blocks are properly made. With the Buckeye Cement Block Machine blocks can be made that will turn water and the large air space will keep the walls from being damp. My blocks are as hard at the end of thirty days as blocks usually are at the end of six months made for sale by block men. Am glad to recommend the Buckeye Cement Block Machine to all who need a first class machine.

Yours respectfully, W. H. CRONK.

Sears, Roebuck & Co., Chicago, Ill. Mayfield, Ky., Nov. 28, 1906.

Gentlemen:—I have just completed an 18-room dwelling, two stories high, using 8x8x16-inch blocks which I made on your Buckeye Cement Block Machine. There are other houses built of cement blocks in this town but everybody says we have the best house in Mayfield. It is the neatest and best looking lot of blocks around here. The Buckeye machine is all that you claim it to be and anyone can take the Buckeye machine and build as fine a house as he could build with a $300.00 machine. We waterproof our blocks. I will give you the formula: Dissolve one and one-half pounds of good bar soap in five gallons of hot water and apply to the blocks while hot, with a whitewash brush. Twenty-four hours later go over your blocks with a solution of one pound of alum dissolved in five gallons of water. This will prevent any water entering the blocks and $2.00 worth of this material will waterproof 4,000 blocks 8x8x16 inches. Your Buckeye machine is all right, and you can't put it too strong. For simplicity it can't be beaten. The machine stands up on the level with the operator which makes it very easy to tamp and carry the blocks away from the machine without any stooping.

Yours respectfully, DUKE BROS.

Sears, Roebuck & Co., Chicago, Ill. Otsego, Mich., Dec. 11, 1906.

Gentlemen:—I received your letter in regard to cement block machine. I will say in regard to it, it is a fine machine for the money and makes perfect blocks. Could not ask for anything better. The higher priced machines could not make any better blocks than the Buckeye Cement Block Machine. We are very much pleased with it. It gives satisfaction in every respect. We have sold the blocks to people to build houses and barns; they make a fine wall. It takes but a few minutes to make a block. I am well satisfied.

Yours respectfully, JAY A. MONROE.

THE AMERICAN HYDRAULIC STONE CO.
Manufacturers of
Building Blocks, Curbing, Sidewalks, all Kinds of Moulded Artificial Stone, Lime, Plaster, Sand and Cement.

Sears, Roebuck & Co., Chicago, Ill. East Liverpool, Ohio, Dec. 1, 1906.

Gentlemen:—I received the Buckeye Cement Block Machine and will say I am more than pleased with it. In my opinion it is the handiest machine on the market today, and I have had four year's experience in making building blocks. It will make just as good and as many blocks as any machine made, regardless of price.

We will want about six more cement block machines in the spring, as we have our own gravel and sand bank. You are at liberty to use my name if it will further the sale of your machine.

I hope you will get a good mixer at a reasonable price and I know you will. Please send me large catalogue and the one you are getting out on block machines.

Yours truly, HENRY CHAMBERS.

P. S.—I have made careful inquiry of those living in hollow block houses as to dampness, heat and cold, and got the reply: No dampness or wet walls and saved one-third fuel in winter and the cement houses were cooler in summer. This is the testimony of three parties living in $10,000.00 houses, at a rental of $60.00 per month.

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MEN'S CUSTOM TAILORING. (Tailor Made Clothing.)

BOOK No. 81G Contains cloth samples of our entire line of men's spring and summer suits at $7.90 to $24.90, made to order.

BOOK No. 82G Contains cloth samples of our entire line of men's made to order suits and trousers in heavy and medium weight fabrics for fall and winter at $8.90 to $24.90.

BOOK No. 87G Contains cloth samples of our entire line of men's made to measure fall and winter overcoats and ulsters.

MEN'S READY MADE CLOTHING.

BOOK No. 83G Contains cloth samples of our entire line of men's corduroy clothing and catalogue of fancy vests.

BOOK No. 84G Contains cloth samples of our complete line of men's light weight spring and summer overcoats and catalogue of top coats, cielette rainproof overcoats, etc.

BOOK No. 86G Contains samples of our entire line of men's light weight outing summer suits at $2.48 and up.

BOOK No. 89G This sample book contains cloth samples of our entire line of men's ready made clothing.

CARD No. 291G Contains cloth samples of our entire line of men's ready made dress suits, Prince Alberts, Tuxedos and full dress garments at $20.00 and $22.00.

CARD No. 191G Contains cloth samples of our complete line of mail carriers', Grand Army and railroad men's uniforms at $8.90 and up.

BOYS' AND CHILDREN'S READY MADE CLOTHING.

BOOK No. 88G Contains cloth samples of our entire line of boys' and children's ready made clothing.

WALL PAPER SAMPLE BOOK. This book contains a fair sized sample of our entire line of wall papers for this season.

CARPETS. For full particulars concerning our line of good sized samples of all kinds of carpeting see page 1902, General Catalogue.

BASEBALL SUITS. Cloth sample booklet showing our complete line of samples of baseball uniforms mailed on request.

BUILDING AND ROOFING PAPER. Samples of all kinds of tar, strawboard and other building and roofing papers.

DRESS GOODS. For full particulars concerning samples of dress goods, silks, etc., free, see page 1074, General Catalogue.

READY MIXED HOUSE AND BARN PAINT. We issue a handsome book showing our entire line of colors and the same is illustrated and fully described in our big General Catalogue.

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WINDMILLS
CERAMIC MOSAIC FLOORS

We will Forfeit Ten Thousand Dollars ($10,000.00) in Cash to any Worthy Charity

if anyone will prove that any other FIVE (5) catalogue houses in the United States selling general merchandise to the consumer exclusively, the same as we do, can show combined sales for the year ending Dec. 31, 1906, aggregating as much as $51,866,875.98. The TEN THOUSAND DOLLARS will be paid to any worthy charity that the party furnishing the proof may direct.

State of Illinois)
) ss.
County of Cook)

Richard W. Sears and John Higgins hereby state that Richard W. Sears is the President and John Higgins is the Auditor of Sears, Roebuck and Company, and that the total sales of Sears, Roebuck and Company, for the twelve months ending December 31st, 1906, amounted to Fifty-One Million Eight Hundred Sixty-Six Thousand Eight Hundred Seventy-Five and 98/100 ($51,866,875.98) Dollars.

Richard W. Sears
President.

John Higgins
Auditor.

HENRY LORENZEN

Subscribed and sworn to before me by Richard W. Sears, President of Sears, Roebuck and Company, and John Higgins, Auditor. this eighth day of February, 1907.

Henry Lorenzen
NOTARY PUBLIC.

TO SETTLE THE QUESTION IN EVERY MIND AT ONCE AND FOREVER

as to which is the **largest mail order house in the United States** we state to you under **oath** just what our sales were for the year ending December 31, 1906, and attach our **Ten Thousand Dollar Challenge** that our business is not only larger than any other mail order house, but **larger than any other five mail order houses** in the United States combined.

Let the next five mail order houses in the United States in the order of their size add their total 1906 sales together and if in the aggregate they have a figure greater than $51,866 875.98 (our sales for 1906), then let them accept our challenge and let us pay the **ten thousand dollars to charity.**

In calling your attention to our **new forty acre home** with its many enormously large buildings, our own railroad yards, and to our many factories, as illustrated and described in the front of our large catalogue, **by far the largest mercantile plant in the world,** we thought it a fitting time to give you exact figures **under oath,** for figures, better than anything else, will tell those interested of the size of this institution and of our place among the large commercial institutions of the country.

JUST IMAGINE, our sales for 1906, amounting to $51,866,875.98, equal an average of over $172,889.00 for every one of the 300 working days of 1906, or with nine hours for a working day, more than $19,209.00 for every hour during 1906, and sales of over $320.00 for every minute of the year of 1906.

SIXTY MILLION DOLLARS SALES is the mark we have set for the coming year, and to reach it easily, with a million or so to spare for good measure, we offer in our big General Catalogue and in our many special catalogues **greater values than ever before, bigger variety of merchandise than ever before, a more liberal profit sharing plan than ever before.**

WE OUTCLASS AND OUTDISTANCE ALL AND EVERY KIND OF COMPETITION.

OUR NEW FORTY ACRE HOME—THE LARGEST MERCANTILE PLANT IN THE WORLD.

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